Grizzly Industrial, Inc.®

MODEL G0679
STROKE/EDGE SANDER
OWNER'S MANUAL

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#JB11085 PRINTED IN TAIWAN

⚠ WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.

Failure to read, understand and follow the instructions given in this manual may result in serious personal injury, including amputation, electrocution or death.

The owner of this machine/equipment is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, blade/cutter integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.

⚠ WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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INTRODUCTION

Manual Accuracy

We are proud to offer this manual with your new machine! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the machine we used when writing this manual. However, sometimes errors do happen and we apologize for them.

Also, owing to our policy of continuous improvement, **your machine may not exactly match the manual**. If you find this to be the case, and the difference between the manual and machine leaves you in doubt, immediately call our technical support for updates or clarification.

For your convenience, we always keep current Grizzly manuals and most updates available on our website at **www.grizzly.com**. Any updates to your machine will be reflected in these documents as soon as they are complete. Visit our site often to check for the latest updates!

Contact Info

We stand behind our machines. If you have any service questions, parts requests or general questions about the machine, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com

If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
C/O Technical Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

Functional Overview

The Model G0679 Stroke/Edge Sander is used to sand large workpieces such as tabletops or doors. For maximum versatility, the belt assembly pivots from horizontal to vertical to allow for edge sanding. When in the horizontal position, the platen press is used to apply sanding pressure to the workpiece and when in the vertical position, the workpiece is pressed into the belt to apply sanding pressure.

To use the sander in the stroke sanding mode, the user locks the belt assembly in the horizontal position, then places the workpiece on the table and raises the table until the workpiece is within ¼" of the belt. The user positions the workstops as necessary to ensure workpiece stability, then turns the machine ***ON***. The user grasps the table handle with one hand and the platen press handle with the other, then applies pressure by pulling the platen press handle downward while sliding the handle back-and-forth along the entire length of the workpiece. To sand the full width of the workpiece, the user moves the table forward-and-backward.

To use the sander in the edge sanding mode, the user adjusts the belt assembly to the desired angle, locks it in place, then opens the belt cover to expose the belt. The user raises the table until it is even with the center portion of the belt, then places the workpiece on the table and positions the workstops as necessary to ensure workpiece stability. The machine is turned ***ON***, and the user moves the workpiece into the belt to perform the sanding operation.

Identification

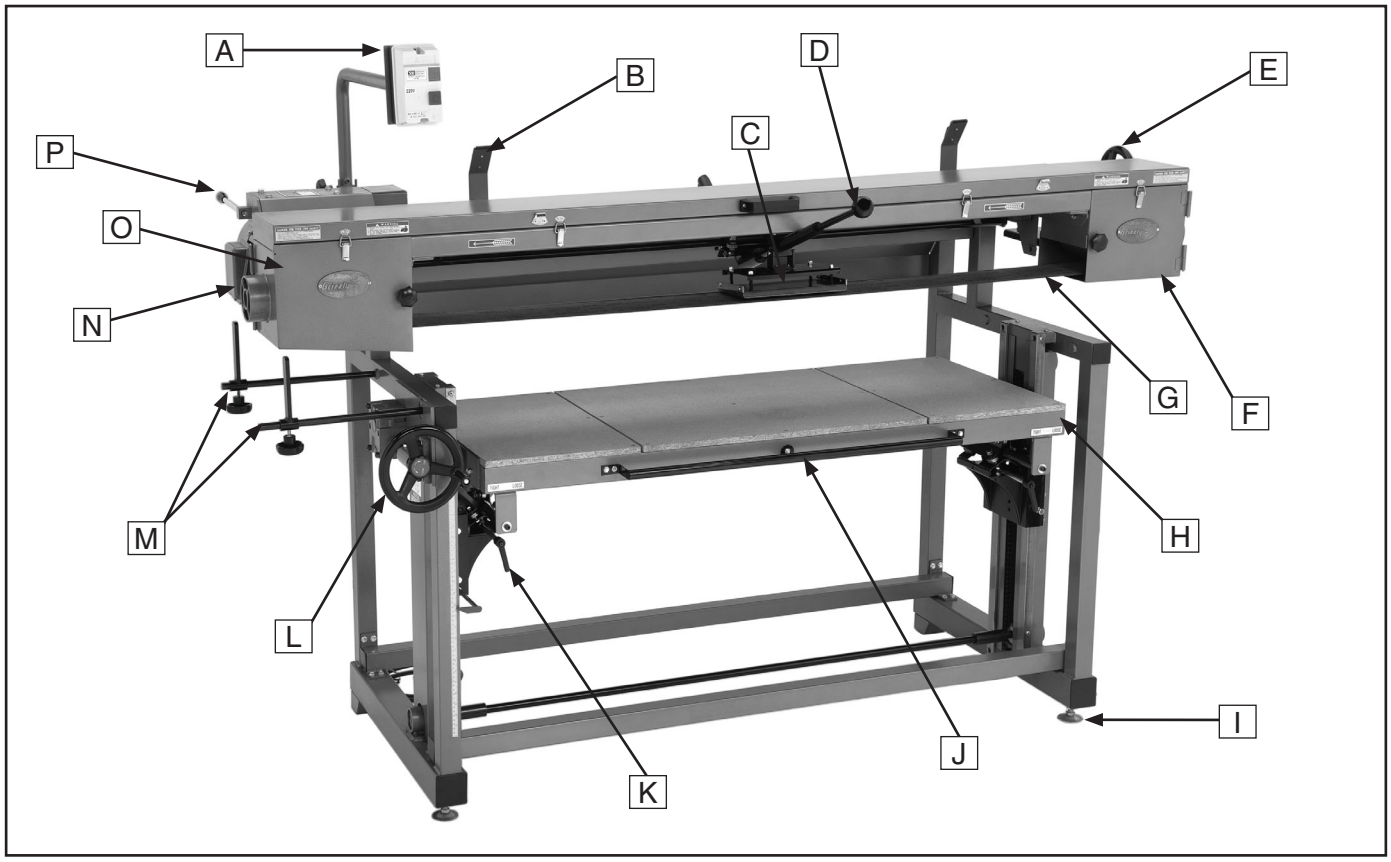


Figure 1. Identification.

A. Magnetic On/Off Switch
B. Belt Cover Open Latch
C. Platen Press
D. Platen Press Handle
E. Belt Tension Handwheel
F. Idler Wheel Cover
G. Sanding Belt
H. Table
I. Adjustable Foot
J. Table Handle
K. Table Travel Lock
L. Table Elevation Handwheel
M. Work Stops
N. Dust Collection Port
O. Drive Wheel Cover
P. Belt Tilt Lever

MACHINE DATA SHEET

Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

MODEL G0679
STROKE/EDGE SANDER

Product Dimensions:

Weight	608 lbs.
Length/Width/Height	98" x 47⅝" x 67½"
Foot Print (Length/Width)	69¼" x 31"

Shipping Dimensions:

Type	Wood Crate
Content	Machine
Weight	756 lbs.
Length/Width/Height	86⅝" x 36¼" x 23⅝"

Electrical:

Switch	Magnetic with Thermal Overload Protection
Switch Voltage	220V
Cord Length	6 ft.
Cord Gauge	14 gauge
Minimum Circuit Size	30 amp
Included Plug	No
Recommended Plug	L6-30

Motor:

Type	TEFC Capacitor Start Induction
Horsepower	3 HP
Voltage	220V
Prewired	220V
Phase	Single
Amps	17A
Speed	1750 RPM
Cycle	60 Hz
Number Of Speeds	1
Power Transfer	Direct Drive
Bearings	Shielded and Permanently Lubricated

Main Specifications:

Table Information

Table Width	59"
Table Length	23¾"
Table Thickness	3"
Horizontal Table Travel	18"
Vertical Table Height Adjustment	21"
Floor-to-Table Height	21⅜"–42¾"

Belt Information

Sanding Belt Width	6"
Sanding Belt Length	186"
Sanding Belt Speed	3600 FPM
Roller Type	Aluminum
Roller Width	6¾"
Roller Diameter	8"

Platen Information

Platen Type	Graphite/Rubber
Platen Length	10½"
Platen Width	6"
Platen Travel	50½

Construction

Base Construction	Steel Tube
Stand Construction	Steel Tube
Table Construction	Steel Tube Foundation with Particle Board Work Surface
Frame Construction	Steel Tube
Paint	Powder Coated

Other Related Information

Number of Dust Ports	2
Dust Port Diameter	4"

Other Specifications:

ISO Factory	ISO 9001
Country Of Origin	Taiwan
Warranty	1 Year
Serial Number Location	ID Label on Front of Machine
Assembly Time	3 Hours

Features:

21" Maximum Workpiece Thickness
Horizontal Belt Position for Stroke Sanding and Vertical Belt Position for Edge Sanding
Sliding Ways Travel on Ball Bearings
Fully Adjustable Belt Tracking and Tension
Motor Brake Quickly Stops Belt Movement

SECTION 1: SAFETY

⚠WARNING

For Your Own Safety, Read Instruction Manual Before Operating this Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

⚠DANGER **Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.**

⚠WARNING **Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.**

⚠CAUTION **Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.**

NOTICE **This symbol is used to alert the user to useful information about proper operation of the machine.**

⚠WARNING

Safety Instructions for Machinery

1. **READ THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
2. **ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses—they are NOT safety glasses.
3. **ALWAYS WEAR A NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Most types of dust (wood, metal, etc.) can cause severe respiratory illnesses.
4. **ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing loss.
5. **WEAR PROPER APPAREL.** DO NOT wear loose clothing, gloves, neckties, rings, or jewelry that can catch in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
6. **NEVER OPERATE MACHINERY WHEN TIRED OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.

⚠WARNING
Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.

8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.

9. **MAKE WORKSHOP CHILDPROOF.** Use padlocks, master switches, and remove start switch keys.

10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power ***OFF*** and allow all moving parts to come to a complete stop before leaving machine unattended.

11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.

12. **KEEP WORK AREA CLEAN AND WELL LIGHTED.** Clutter and dark shadows may cause accidents.

13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Grounded cords minimize shock hazards. Undersized cords create excessive heat. Always replace damaged extension cords.

14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY**. Make sure switch is in OFF position before reconnecting.

15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**

17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery ***ON***.

18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding or misaligned parts, broken parts, loose bolts, and any other conditions that may impair machine operation. Repair or replace damaged parts before operation.

19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. Improper accessories increase risk of injury.

20. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.

21. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.

22. **DO NOT OVERREACH.** Maintain stability and balance at all times.

23. **MANY MACHINES CAN EJECT WORKPIECES TOWARD OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."

24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY**.

25. **CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Be aware of the type of dust you are exposed to and always wear a respirator designed to filter that type of dust.

⚠WARNING
Additional Safety for Stroke/Edge Sanders

1. **RESPIRATOR AND SAFETY GLASSES.** Always wear a respirator and safety glasses while operating the machine. Dust and chips are created when sanding. Some debris will be ejected, becoming hazards to the eyes and lungs.

2. **DUST COLLECTION SYSTEM**. Never operate the sander without an adequate dust collection system in place and running.

3. **HAND PROTECTION**. DO NOT place hands near, or in contact with, sanding belt during operation. DO NOT allow fingers to get pinched between the workpiece and the table. This may pull the operator's hand into the machine and cause serious injury!

4. **INSPECTING WORKPIECES**. Always inspect workpiece for nails, staples, knots, and other imperfections that could be dislodged and thrown from the machine during sanding operations.

5. **SANDING CORRECT MATERIAL.** Only sand natural wood stock with this sander. We do not recommend sanding MDF, particle board, laminates, plastics, metal, glass, ceramics, and any other synthetic products, or products containing asbestos or lead paint. Many of these products contain hazardous dust, or will greatly reduce the life of your sanding paper.

6. **UNATTENDED OPERATION**. Never leave the machine running unattended.

7. **CLOTHING.** DO NOT wear loose clothing while operating this machine. Roll up or button sleeves at the cuff.

8. **FEEDING STOCK WHEN EDGE SANDING.** Firmly grasp the workpiece with both hands and ease it into the machine using light pressure. DO NOT jam the workpiece into the machine during operation. Feed the workpiece against the direction of rotation. DO NOT sand tapered or pointed stock with the point facing into the feed direction. Never sand more than one piece of stock at a time.

9. **REPLACING SANDPAPER**. Replace sanding paper when it becomes worn. DO NOT operate the sander with a damaged or badly worn sandpaper.

10. **MAINTENANCE AND ADJUSTMENTS**. Perform machine inspections and maintenance service promptly when called for. Disconnect power before performing maintenance or adjustments on the sander.

11. **EXPERIENCING DIFFICULTIES**. Any problem, with the exception of conveyor belt tracking that is concerned with any moving parts or accessories, must be investigated and corrected with the power disconnected, and after all moving parts have come to a complete stop.

⚠WARNING

Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to decrease the risk of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

SECTION 2: CIRCUIT REQUIREMENTS

220V Operation

⚠WARNING

Serious personal injury could occur if you connect the machine to power before completing the setup process. DO NOT connect the machine to the power until instructed later in this manual.

⚠WARNING

Electrocution or fire could result if machine is not grounded and installed in compliance with electrical codes. Compliance MUST be verified by a qualified electrician!

Full Load Amperage Draw

This machine draws the following amps under maximum load:

Amp Draw..... 17 Amps

Power Supply Circuit Requirements

You MUST connect your machine to a grounded circuit that is rated for the amperage given below. Never replace a circuit breaker on an existing circuit with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes. **If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, consult a qualified electrician.**

Minimum Circuit Size.....30 Amps

Power Connection Device

The type of plug required to connect your machine to power depends on the type of service you currently have or plan to install. We recommend using the plug shown in **Figure 2**.

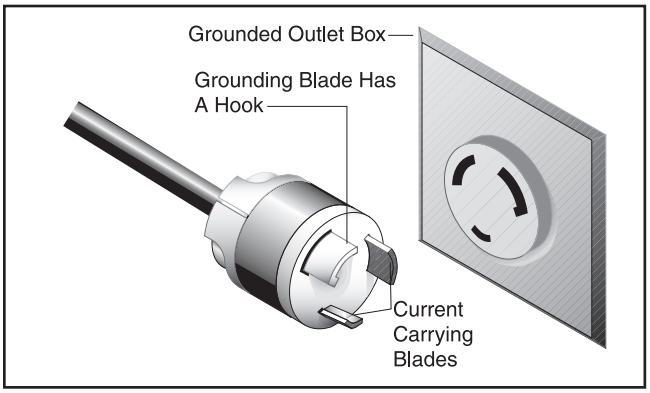


Figure 2. NEMA L6-30 plug and receptacle.

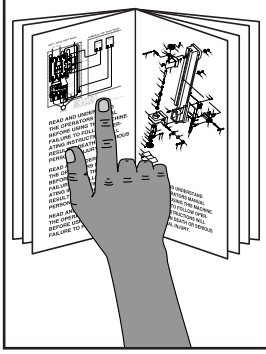
Extension Cords

Using extension cords may reduce the life of the motor. Instead, place the machine near a power source. If you must use an extension cord:

- Use at least a 12 gauge cord that does not exceed 50 feet in length!
- The extension cord must also have a ground wire and plug pin.
- A qualified electrician MUST size cords over 50 feet long to prevent motor damage.

SECTION 3: SETUP

Setup Safety



⚠WARNING

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!

⚠WARNING

Wear safety glasses during the entire setup process!

⚠WARNING

This machine and its components are very heavy. Get lifting help or use power lifting equipment such as a forklift to move heavy items.

Items Needed for Setup

The following items are needed to complete the setup process, but are not included with your machine:

Description	Qty
• Assistant	1
• Safety Glasses (For Each Person)	1
• Square	1
• Dust Collection System	1
• Flexible Dust Hoses 4"	2
• Hose Clamp 4"	2

Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover the machine is damaged, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, inventory the contents.

Inventory

The following is a description of the main components shipped with your machine. Lay the components out to inventory them.

Note: *If you can't find an item on this list, check the mounting location on the machine or examine the packaging materials carefully. Occasionally we pre-install certain components for shipping purposes.*

Inventory A: (Figure 3)	Qty
A. Table Elevation Handwheel	1
B. Belt Tension Handwheel	1
C. Work Stops	2
D. Belt Tilt Lever	1
E. Belt Tilt Lock Handle	1
F. Wrenches (10/12, 12/14, 17/19mm)	1 Ea.
G. Switch Boom Knob	1
H. Belt Tilt Lock Knobs	2
I. Hex Wrenches (4, 5, 6, 8mm)	1 Ea.

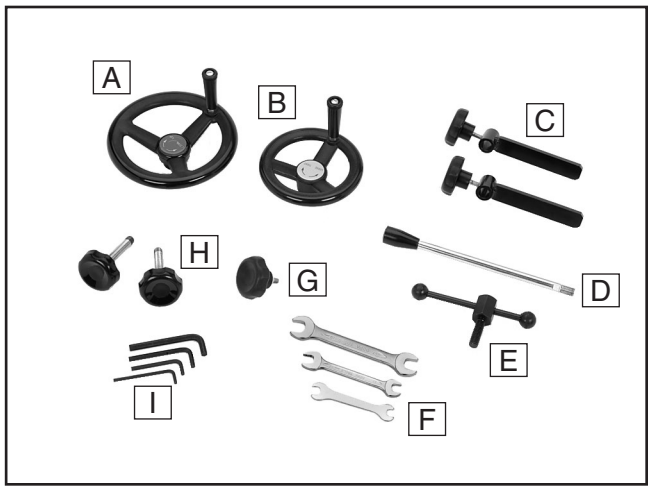
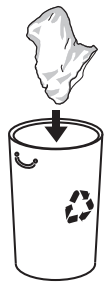


Figure 3. Inventory A.



⚠WARNING

SUFFOCATION HAZARD!

Immediately discard all plastic bags and packing materials to eliminate choking/suffocation hazards for children and animals.

Inventory B: (Figure 4)	Qty
J. Platen Press Assembly	1
K. Platen Press Counterweight	1
L. Belt Cover Latch Brackets	2
M. Table Work Stop	1

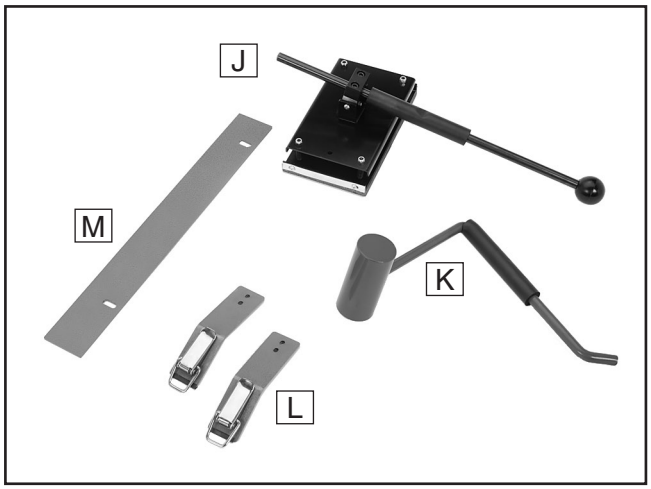


Figure 4. Inventory B.

Inventory C: (Figure 5)	Qty
N. Sanding Belt 6 x 186"	1
O. Table Slide Rods	1
P. Belt Tilt Lock Bracket	1
Q. Work Stop Rods	2
R. Belt Tilt Pivot Bolts	2
S. Lock Nuts 3/8-16	2

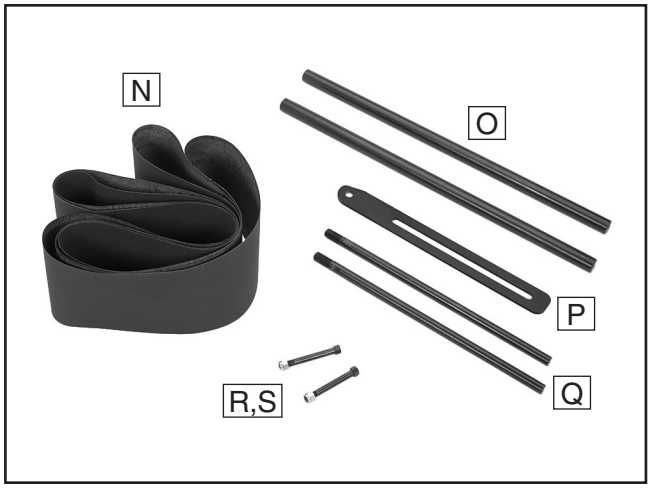


Figure 5. Inventory C.

If any nonproprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

Inventory D: (Figure 6) **Qty**

A. Table Assembly 1
B. Idler Wheel Assembly 1

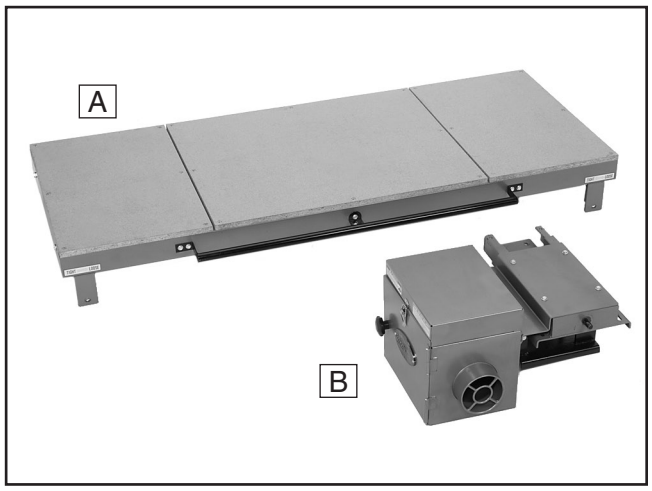


Figure 6. Inventory D.

Inventory E: (Figure 7) **Qty**

C. Left Upright Assembly 1
D. Right Upright Assembly 1

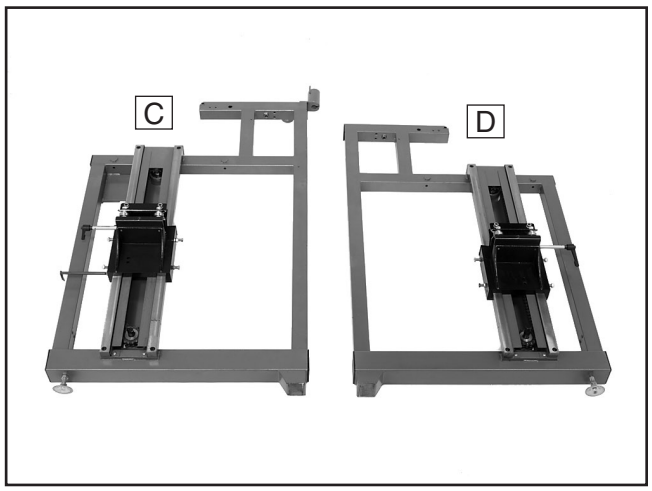


Figure 7. Inventory E.

Hardware Bag: (Not Shown) **Qty**

- Flange Bolts 5/16-18 x 1/2" (Misc.) 32
- Flange Bolts 1/4-20 x 1/2" (Belt cover, latches) 7
- Cap Screws 1/4-20 x 1/2" (Platen press rod) 4
- Cap Screws 5/16-18 x 3/4" (Table) 4
- Flat Washers 5/16" (Table) 4
- Phillips Head Screws 1/4-20 x 1/2" (Rear cover) 6
- Hex Nuts 1/4-20 (Belt cover) 3
- Lock Nut 1/2"-13 (Pivot lock bracket) 1
- Flat Washers 1/2" (Pivot lock knobs) 2

Inventory F: (Figure 8) **Qty**

E. Platen Assembly with Motor 1
F. Rear Cover 1
G. Cross Braces 3
H. Platen Rail Assembly 1

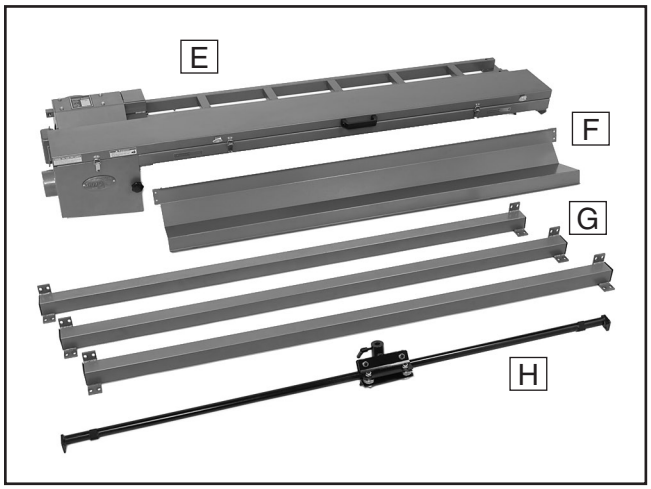


Figure 8. Inventory F.

Inventory G: (Figure 9) **Qty**

I. Table Elevation Rod Assembly 1
J. On/Off Switch Boom Assembly 1

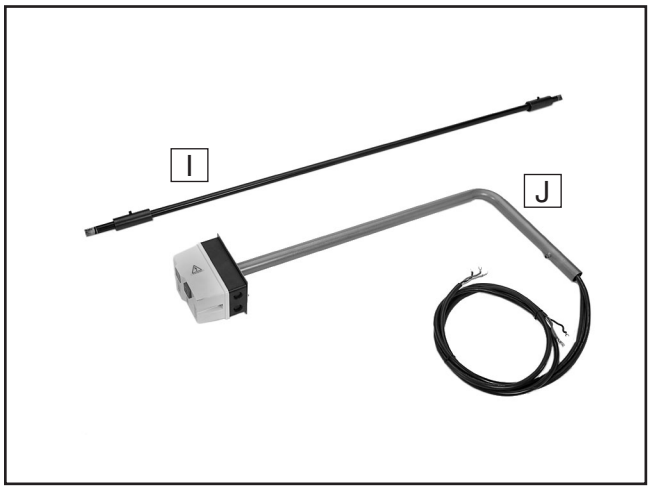
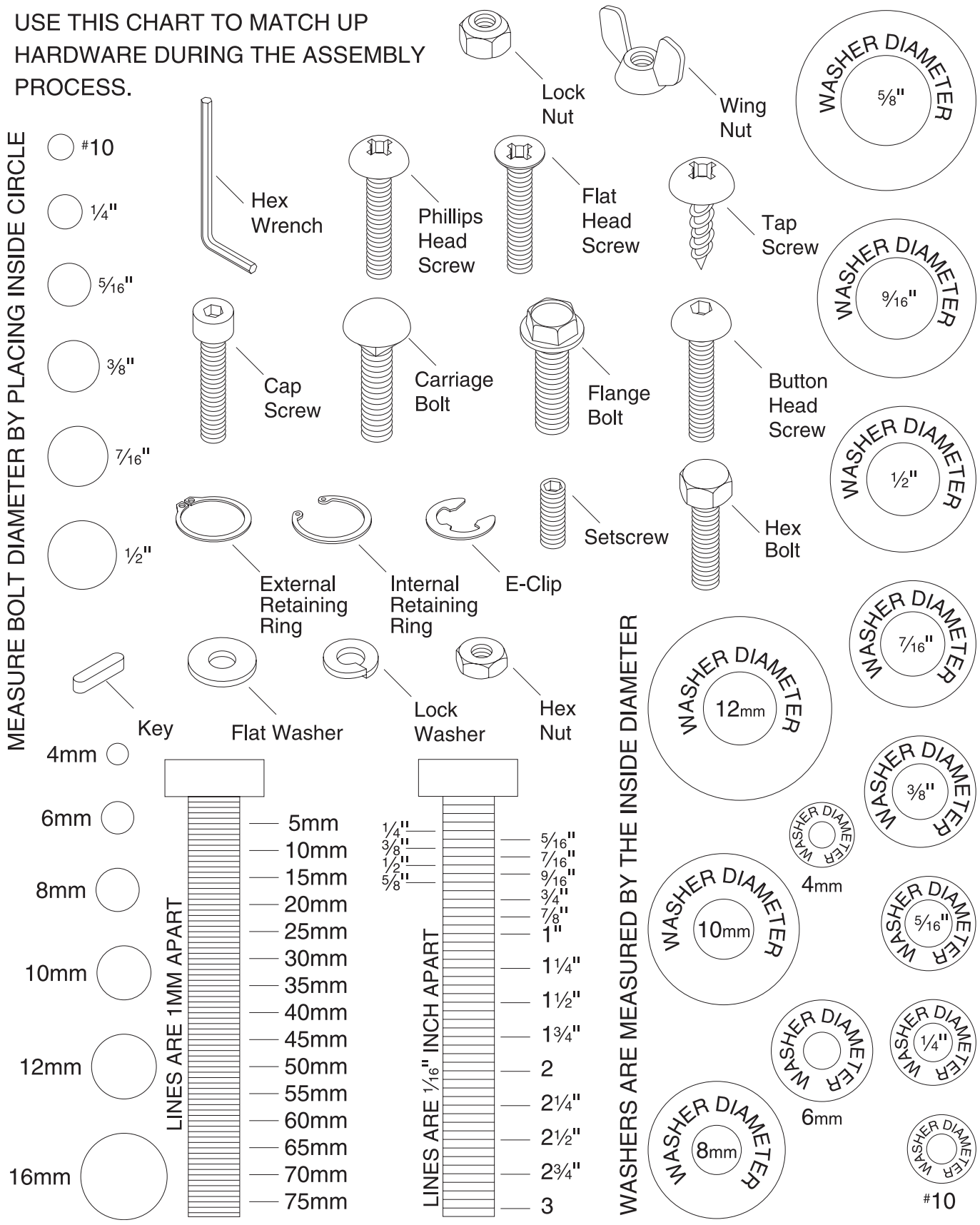


Figure 9. Inventory H.

Hardware Recognition Chart

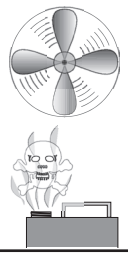


Clean Up

The unpainted surfaces are coated with a waxy oil to prevent corrosion during shipment. Remove this protective coating with a solvent cleaner or degreaser, such as shown in **Figure 10**. For thorough cleaning, some parts must be removed. **For optimum performance, clean all moving parts or sliding contact surfaces.** Avoid chlorine-based solvents, such as acetone or brake parts cleaner that may damage painted surfaces. Always follow the manufacturer's instructions when using any type of cleaning product.

⚠WARNING

Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. DO NOT use these products to clean the machinery.



⚠CAUTION

Many cleaning solvents are toxic if inhaled. Minimize your risk by only using these products in a well ventilated area.

G2544—Solvent Cleaner & Degreaser
H9692—Orange Power Degreaser
Great products for removing shipping grease.

Figure 10. Cleaner/degreasers available from Grizzly.

Site Considerations

Floor Load

Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some residential floors may require additional reinforcement to support both the machine and operator.

Placement Location

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 11** for the minimum working clearances.

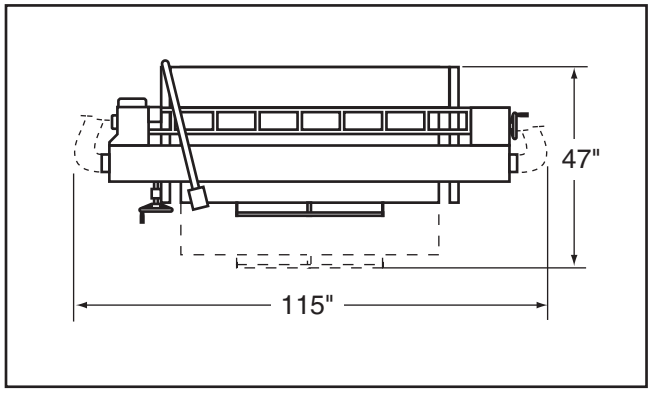
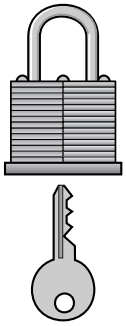


Figure 11. Minimum working clearances.



⚠CAUTION

Children and visitors may be seriously injured if unsupervised around this machine. Lock entrances to the shop or disable start switch or power connection to prevent unsupervised use.

Assembly

After you have removed all of the components from the shipping crate and checked the inventory, assemble the machine.

Items required	**Qty.**
Assistant	1
Safety Glasses (For Each Person)	1 Pair
Square	1

To assemble your machine:

1. Connect one of the braces to the lower portion of one of the upright assemblies with (4) 5/16-18 x 1/2 flange bolts, as shown in **Figure 12**. Have an assistant stabilize the upright assembly during fastening. Do not yet fully tighten the bolts.

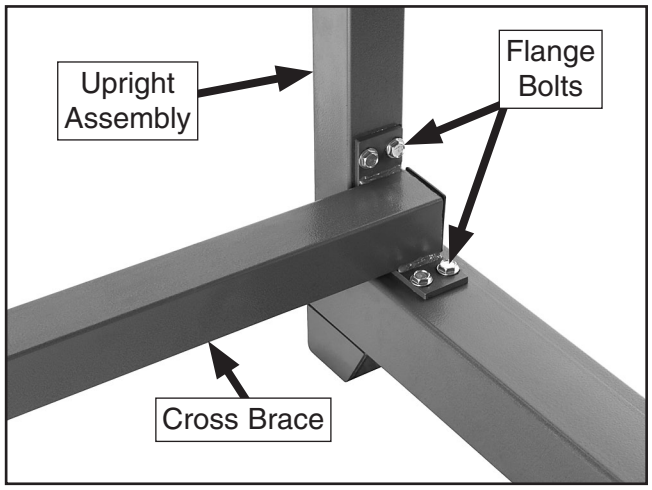


Figure 12. Cross brace attachment.

2. Connect a second cross brace in the same manner.

3. Attach the other upright to the two cross braces with (8) 5/16-18 x 1/2 flange bolts, as shown in **Figure 13**. Have an assistant stabilize the upright assembly during fastening. Do not yet fully tighten the bolts.

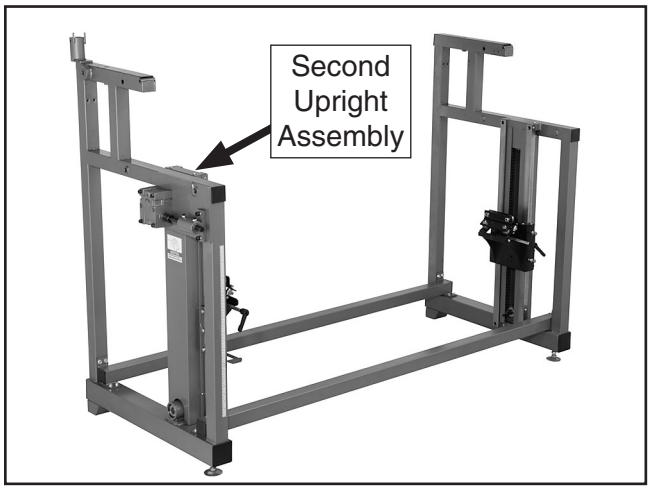


Figure 13. Second upright assembly.

4. Attach the third cross brace to the top location of the uprights with (8) 5/16-18 x 1/2 flange bolts, as shown in **Figure 14**. Use a square to make sure the machine is square vertically and horizontally, then tighten all 24 flange bolts.

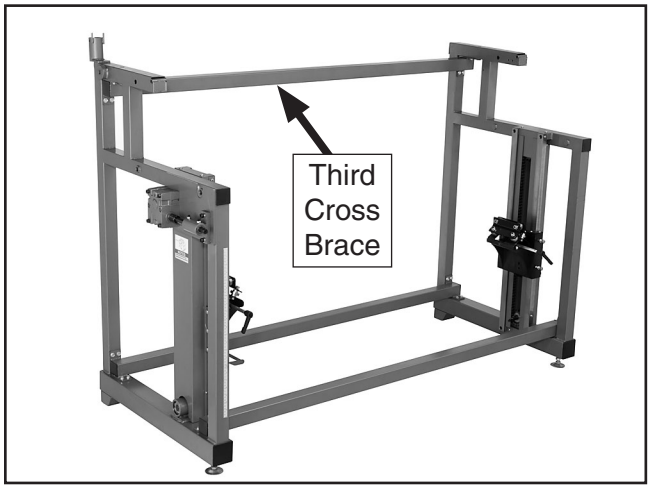


Figure 14. Third cross brace.

5. Connect the table elevation rod to the left and right side elevation assemblies. Place the notch in the end of the rod against the notch in the shaft at the base of the elevation assembly, slide the coupler over the joint, then tighten the set screw, as shown in **Figure 15**.

Note: *To make sure both sides are set evenly, fully lower both before connecting the table elevation rod.*

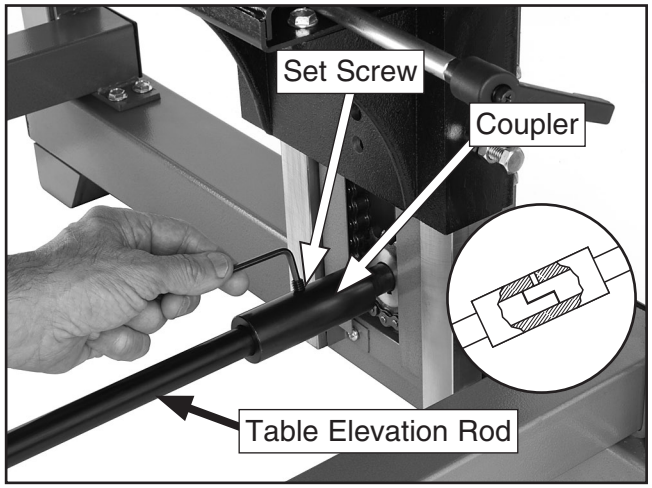


Figure 15. Table elevation rod.

6. With the help of an assistant, place the platen assembly onto the assembled frame, as shown in **Figure 16**.

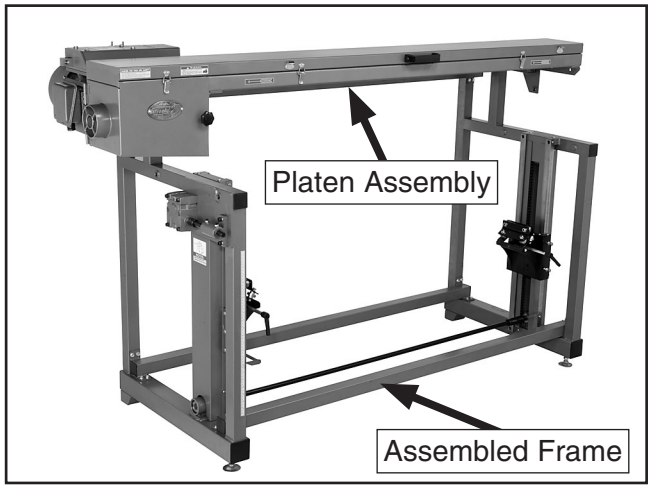


Figure 16. Platen assembly.

7. Secure the motor and platen assembly with the pivot bolts, lock nuts, platen lock knobs, and ½" flat washers, as shown in **Figure 17**.

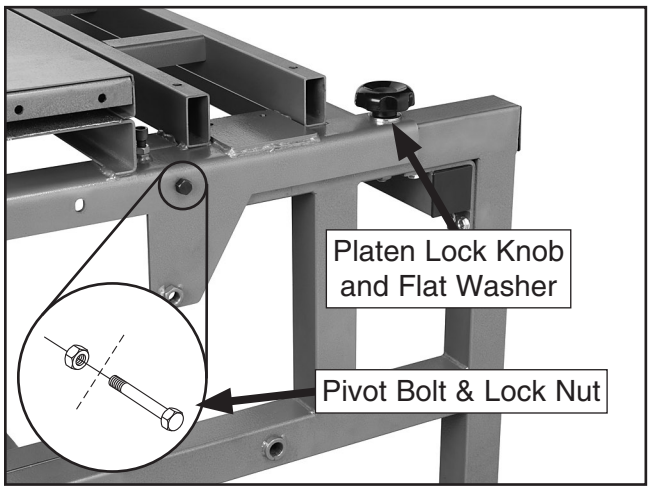


Figure 17. Pivot bolt, nut, and knob.

8. Assemble the lock bracket by placing the bracket over the stud and securing it with the ½"-13 lock nut, then inserting the lock handle through the bracket slot and into the threaded hole, as shown in **Figure 18**.

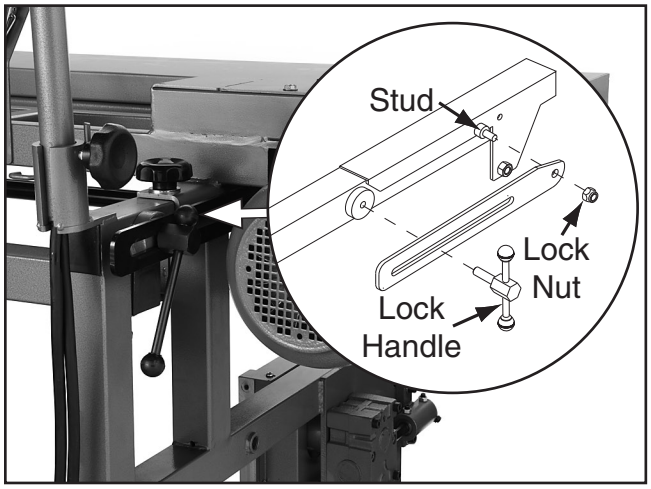


Figure 18. Lock bracket.

9. Attach the two belt cover latch assemblies to the platen assembly frame with (4) ¼-20 x ½ flange bolts, as shown in **Figure 19**.

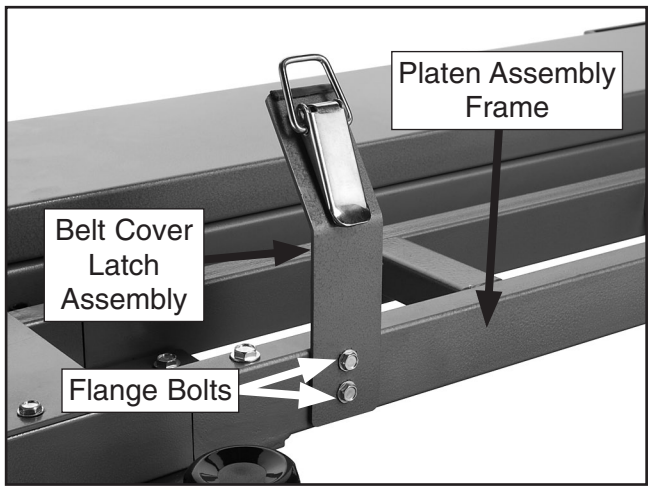


Figure 19. Lid latches.

10. Connect the idler wheel assembly to the platen assembly frame with (4) 5/16-18 x ½ flange bolts, as shown in **Figure 20**.

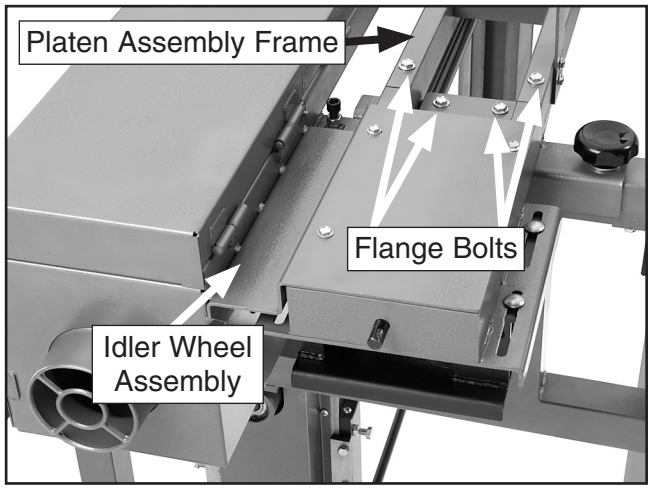


Figure 20. Idler wheel assembly.

11. Secure the idler wheel box to the platen assembly with (2) 5/16-18 x ½ flange bolts and 5/16-18 hex nuts, as shown in **Figure 21**.

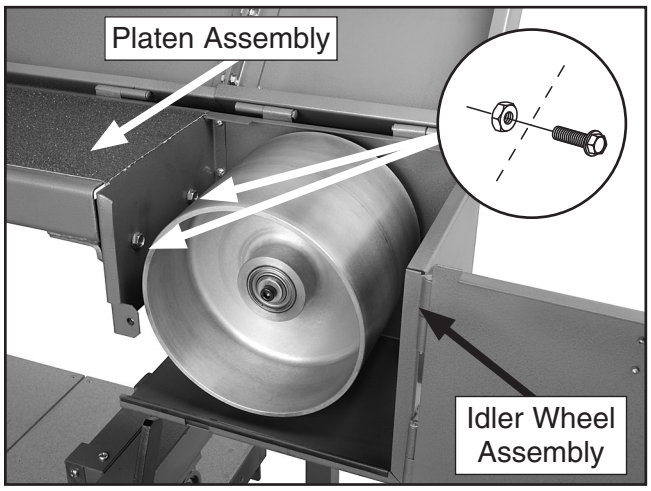


Figure 21. Idler wheel box.

12. Open the platen cover, align it with the idler wheel cover, then secure the two together with (3) ¼-20 x ½ flange bolts and (3) ¼-20 hex nuts, as shown in **Figure 22**. Close and latch the platen cover.

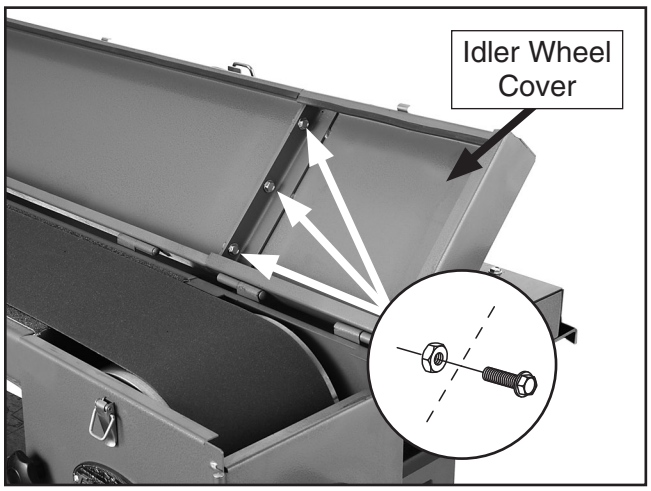


Figure 22. Platen cover connection.

13. Place the switch boom into the switch boom socket and secure with the lock knob, as shown in **Figure 23**.

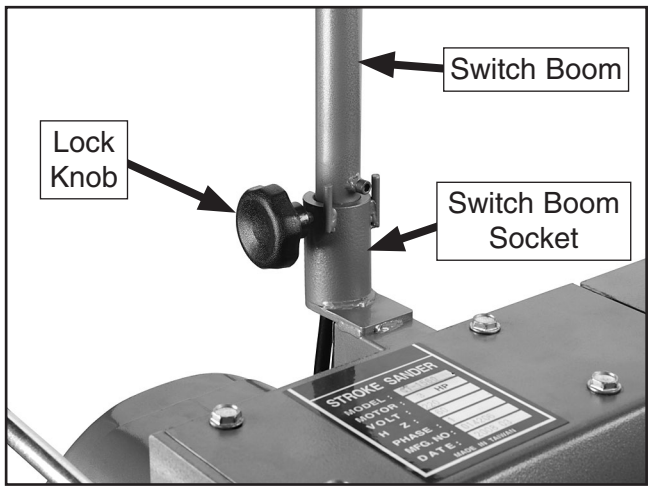


Figure 23. Switch boom.

14. Slide the two table rails into the table bearing assemblies on both sides of the frame (**Figure 24**).

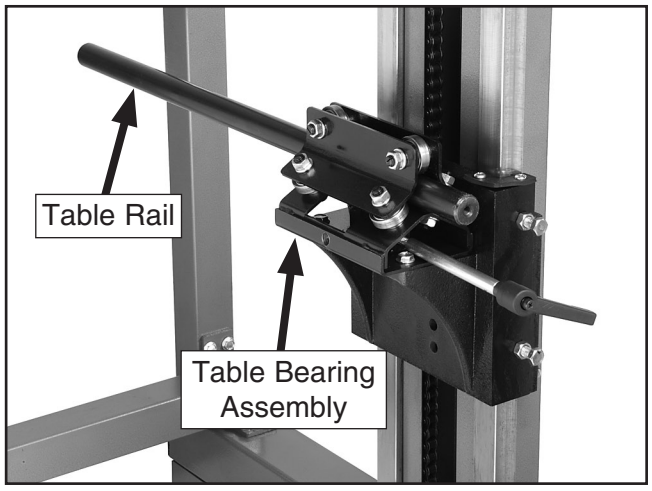


Figure 24. Table rails.

15. With the help of an assistant, place the table over the table rails and secure it with the (4) 5/16-18 x 3/4" cap screws and 5/16" flat washers (**Figure 25**).

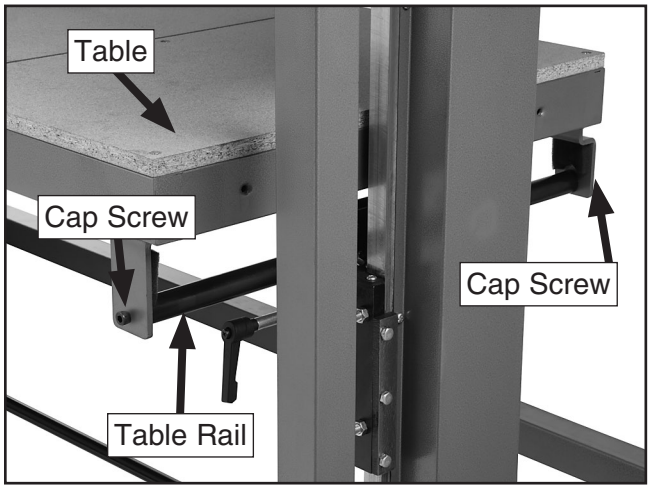


Figure 25. Table mounting.

16. Attach the rear cover to the left and right uprights with the (6) 1/4-20 x 1/2" Phillips head screws, as shown in **Figure 26**.

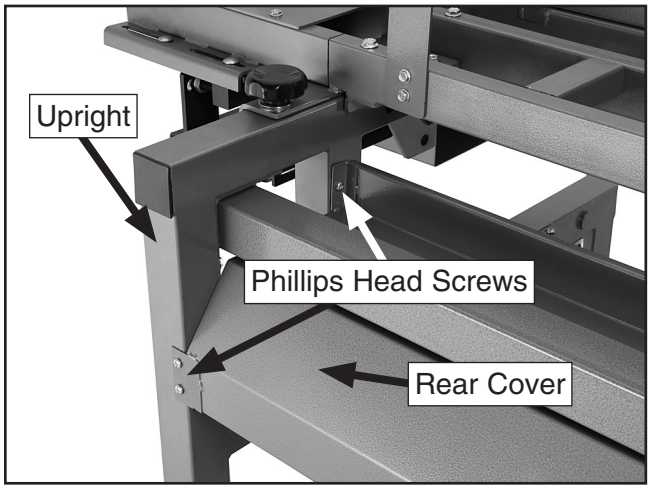


Figure 26. Rear cover.

17. Attach the platen press rail assembly to the left and right uprights with the (4) ¼-20 x ½" cap screws, as shown in **Figure 27**.

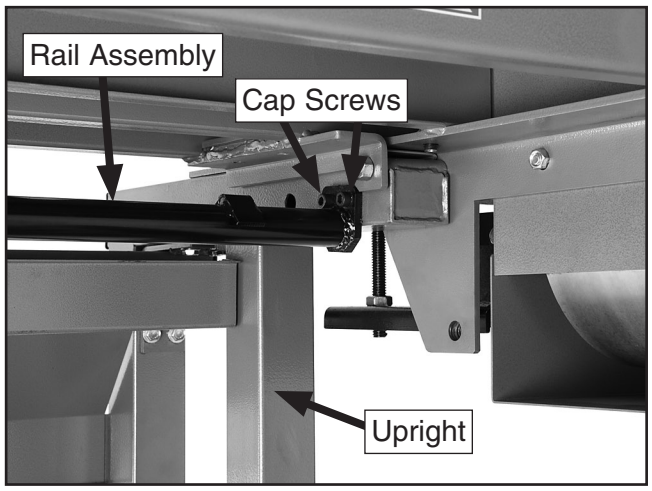


Figure 27. Platen press rail assembly.

18. Insert the platen press assembly and the platen press counterweight into the platen press slide, then tighten the lock lever and cap screw, as shown in **Figure 28**.

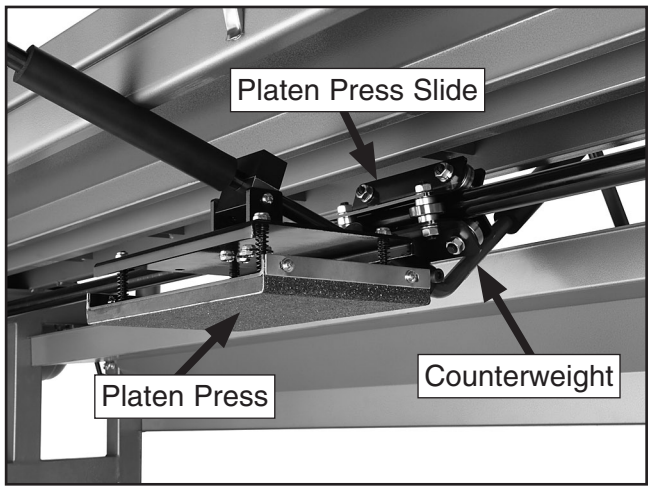


Figure 28. Platen press and counterweight.

19. Slide the larger handwheel on the elevation control shaft and the smaller handwheel on the belt tension shaft, then secure each by tightening the set screws and lock nuts (**Figure 29**).

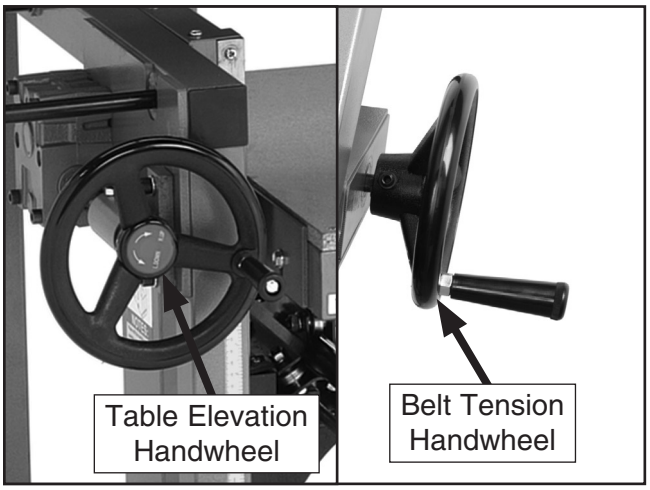


Figure 29. Handwheel Attachment.

20. Attach the table stop with (2) 5/16-18 x ½ flange bolts (**Figure 30**).

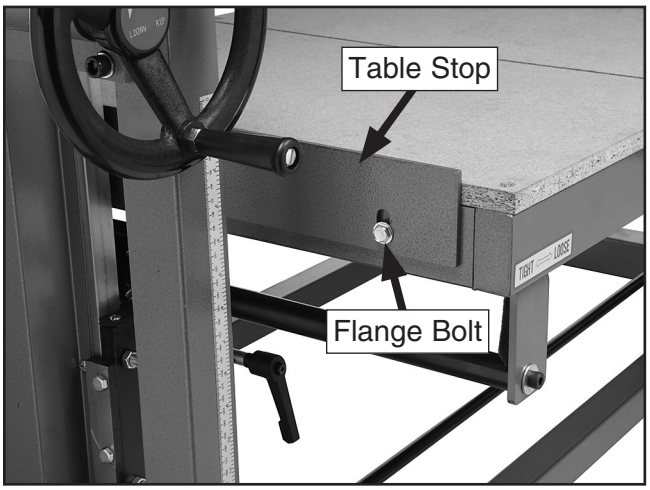


Figure 30. Table stop attachment.

21. Attach the auxilliary workstop rods by threading the workstop rods into the machine base, then sliding the workstops over the rods and tightening the knobs. (**Figure 31**).

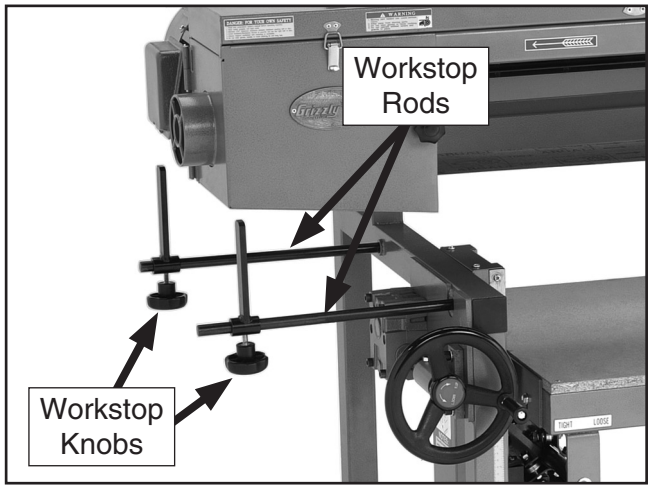


Figure 31. Auxiliary workstops.

22. Thread the belt tilt lever into the platen assembly, as shown in **Figure 32**.

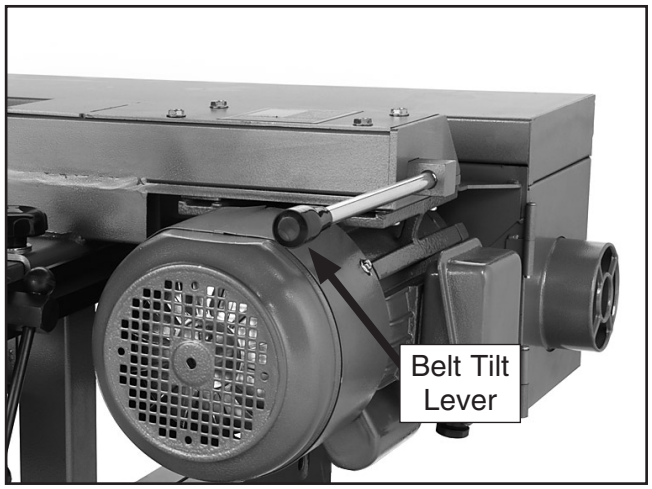


Figure 32. Belt tilt lever.

Machine Leveling

Once assembly is complete, move your machine into position, then level it. Use a level to check from side-to-side and front-to-back.

To adjust for level from side-to-side, use shims under the rear feet of the machine.

To level from front-to-back, use the leveling feet. Thread each foot in or out as necessary, then tighten the jam nut to secure it in position (**Figure 33**).

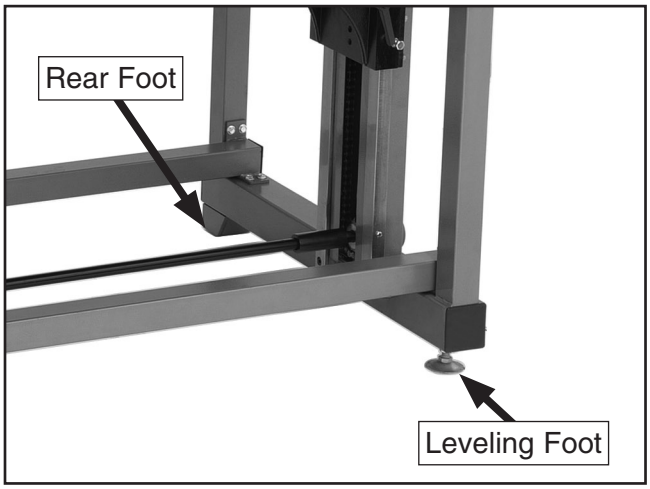


Figure 33. Machine leveling.

Dust Collection

⚠CAUTION

DO NOT operate the Model G0679 without an adequate dust collection system. This sander creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

To connect a dust collection hose:

1. Fit the 4" flexible dust hose over the dust ports located at each end of the belt assembly, as shown in **Figure 34**, and secure them in place with hose clamps.

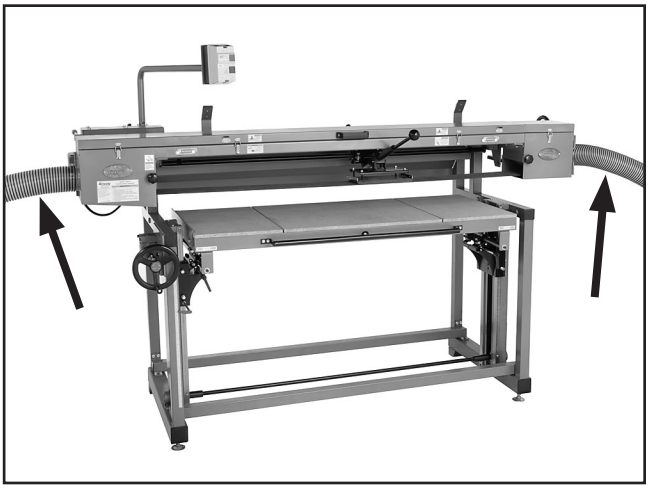


Figure 34. Dust hose attached to dust ports.

2. Tug the hoses to make sure they do not come off. **Note:** *A tight fit is necessary for proper performance.*

Test Run

Once the assembly is complete, test run your machine to make sure it runs properly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review the **Troubleshooting** on **Page 33**.

If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

To test run the machine:

1. Make sure you have read the safety instructions at the beginning of the manual and that the machine is setup properly.

2. Make sure all tools and objects used during setup are cleared away from the machine.

3. Connect the machine to the power source.

4. Tension the belt so that less than ½" of sag is observed along its length.

5. Turn the machine ***ON***.

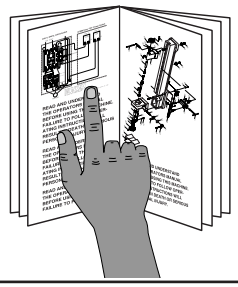
6. Listen and watch for abnormal noises or actions. The machine should run smoothly with little or no vibration or rubbing noises.

   —Strange or unusual noises should be investigated and corrected before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.

7. Turn the machine ***OFF***.

SECTION 4: OPERATIONS

Operation Safety

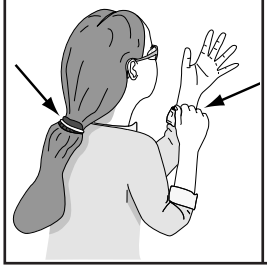


⚠WARNING

To reduce the risk of serious injury when using this machine, read and understand this entire manual before beginning any operations.

⚠WARNING

Damage to your eyes and lungs could result from using this machine without proper protective gear. Always wear safety glasses and a respirator when operating this machine.



⚠WARNING

Loose hair, clothing, or jewelry could get caught in machinery and cause serious personal injury. Keep these items away from moving parts at all times to reduce this risk.

NOTICE

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Basic Controls

Use **Figures 35–36** and the descriptions below to become familiar with the basic controls of the machine.

ON/OFF Switch: Turns the Motor ON/OFF.

Table Elevation Handwheel: Raises and lowers the table to allow for different size workpieces.

Table Work Stop: Can be raised to provide workpiece stability and prevent kickback, and can be lowered for larger workpieces.

Auxiliary Work Stops: Used to secure workpieces that are larger than the table.

Table Depth Indicator: Displays the distance between the table surface and the belt.

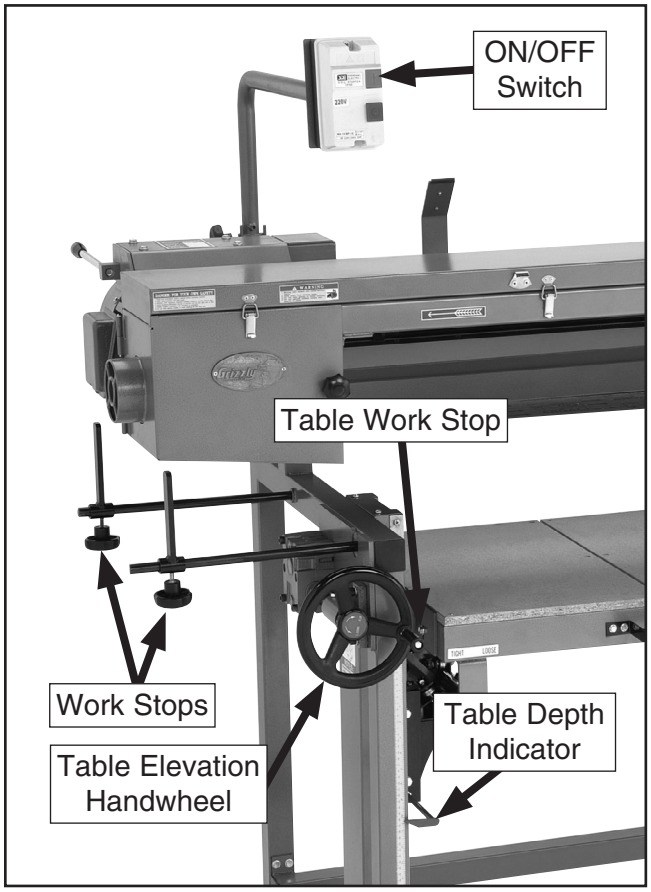


Figure 35. Basic controls.

ON/OFF Switch: Powers the motor, turning the sanding belt.

Belt Tension Handwheel: Adjusts the amount of tension that is placed on the sanding belt.

Platen Press Handle: Used to exert platen pressure through the sanding belt and against the workpiece. Slides along the length of the table to allow complete sanding coverage.

Table Movement Handle: Allows for easy and safe movement of the table forward and backward to provide complete sanding coverage.

Table Travel Lock (right side shown): Locks the horizontal table travel to prevent unwanted movement during use.

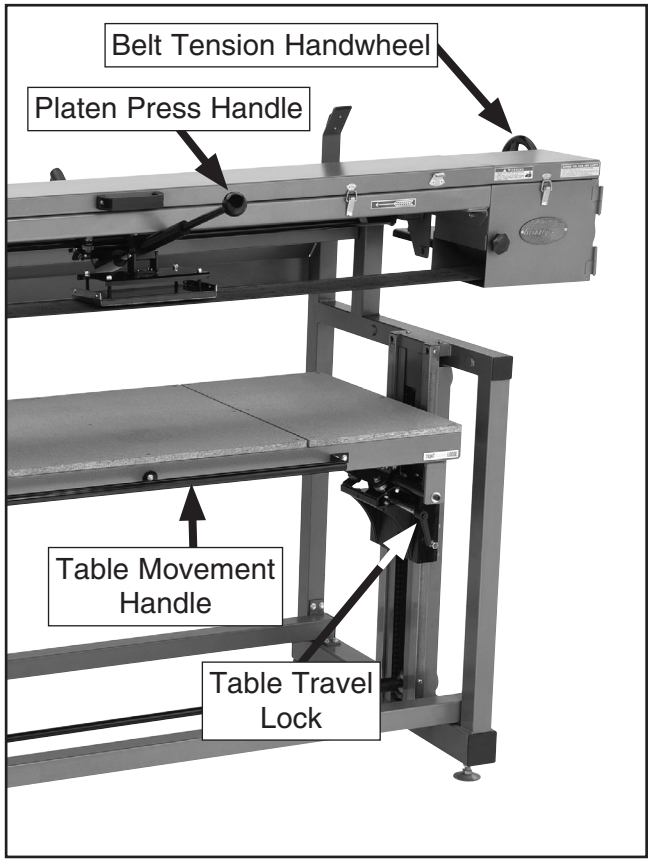


Figure 36. Basic controls (continued).

Table Movement

The table on the Model G0679 can be moved both vertically and horizontally.

Vertical Table Movement

Vertical movement is used to accommodate workpieces of different thicknesses and once set for a specific workpiece, doesn't need to be changed.

1. Place the workpiece on the table.

2. Turn the table elevation handwheel to raise the table until the workpiece is ¼"–½" below the sanding belt (**Figure 37**).

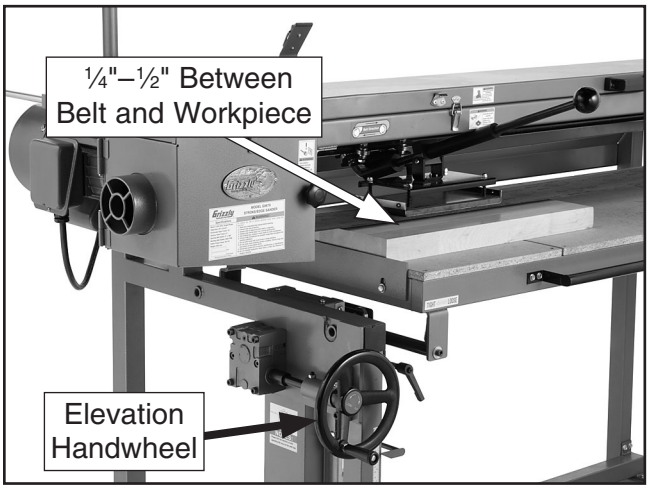


Figure 37. Vertical table movement.

Note: *Due to the locking nature of the worm-drive gearbox, no lock is needed to prevent vertical table movement.*

Horizontal Table Movement

Horizontal table movement is used together with the platen press movement to allow complete sanding of workpieces with large surface areas. Horizontal table movement can be locked when table movement is not desired.

1. Make sure the horizontal table travel locks are released by rotating them counterclockwise until the table moves freely (**Figure 38**).

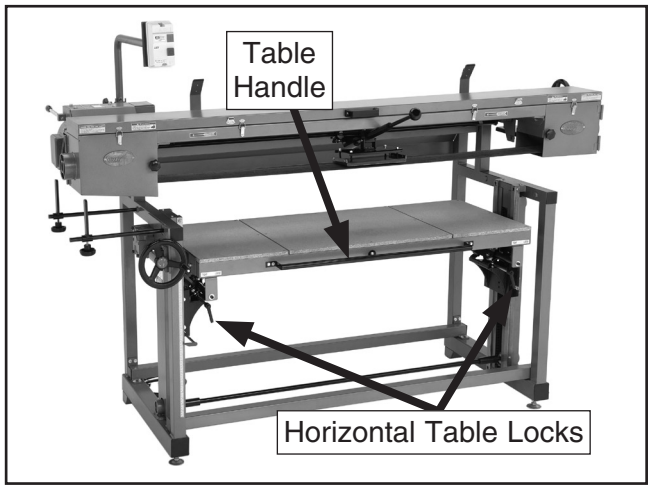


Figure 38. Horizontal table movement.

2. Push or pull the table handle to move the table forward and backward.

Note: *To lock the horizontal table movement, turn the table travel locks ⅓ of a turn clockwise. To release the horizontal table movement, turn the table travel locks ⅓ of a turn counterclockwise. Be careful not to overtighten the lock handles. Doing so may cause damage to the machine.*

Workstops

The Model G0679 is equipped with two workstop mechanisms. The table workstop is used on workpieces that fit entirely on the table and the auxiliary workstops are used on workpieces that are larger than the table.

Make sure the workstops are positioned to secure the workpiece against the direction of the belt.

- When the sander is in the stroke sanding mode, the workstops must be placed on the left side of the machine.

- When the sander is in edge sanding mode, the work stops must be placed on the right side of the machine.

⚠WARNING

The belt speed on the Model G0679 is 3600 FPM, or over 40 MPH. A workpiece ejected at this speed could cause serious personal injury and property damage. Always use the workstops and be sure they are in the correct position and secured before using the machine.

Table Workstop

1. Loosen the flange bolts that hold the workstop to the table (**Figure 39**).

—If the workstop must be repositioned to the other side of the machine, remove the flange bolts completely and relocate the work stop as needed, then re-thread the flange bolts into the appropriate holes.

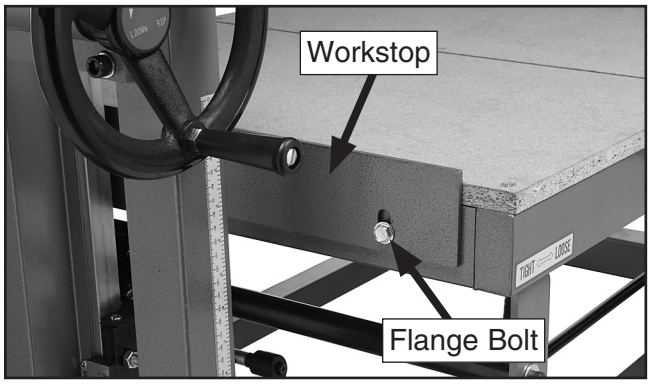


Figure 39. Table workstop.

2. Slide the workstop up as far as it will go. It will extend approximately ⅜" above the surface of the table, providing a lip for the workpiece to rest against during use.

3. To lower the table workstop, loosen the flange bolts that hold the workstop to the table, lower the work stop so that it is below the surface of the table, then tighten the flange bolts to prevent them from rattling loose during use.

Auxiliary Workstops

1. Loosen the workstop knobs, rotate the workstops so the knob is facing down, then position the workstops in the location needed to properly support the workpiece (**Figure 40**).

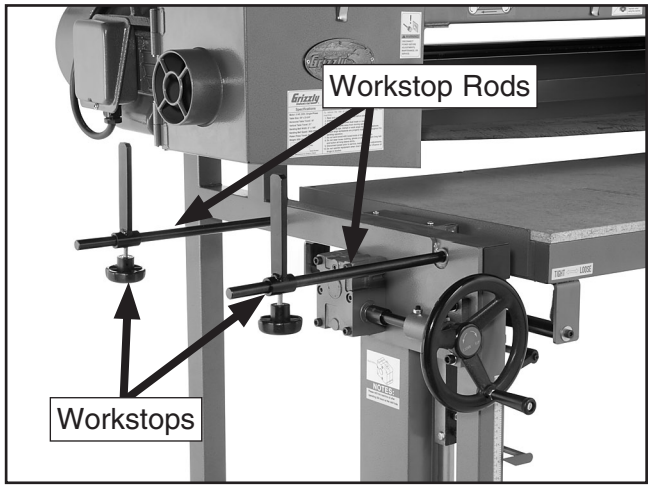


Figure 40. Auxiliary workstops.

—If the workstops must be repositioned to the other side of the machine, un-thread and remove the workstop rods from the machine base and re-thread them into the other side of the machine before positioning the workstops.

2. Tighten the work knobs.

Stroke/Edge Sander Conversion

For maximum versatility, the Model G0679 functions both as a stroke sander and an edge sander. Conversion from one to the other takes only a few minutes and requires removing the platen press and counterweight, pivoting the belt assembly, adjusting the table position, and relocating the workstops.

To convert the machine from stroke sander to edge sander:

1. DISCONNECT SANDER FROM POWER!

2. Lower the table until the indicator reads 7" or greater to provide adequate clearance for tilting the belt assembly.

3. Slide the platen press assembly all the way to the left and lift the counterweight over the small hook located on the rear of the machine to secure it in place. Remove the platen press by loosening the handle that secures it in place.

4. Release the belt cover latches to open the belt cover, then secure it in the open position using the two latches shown in **Figure 41**.

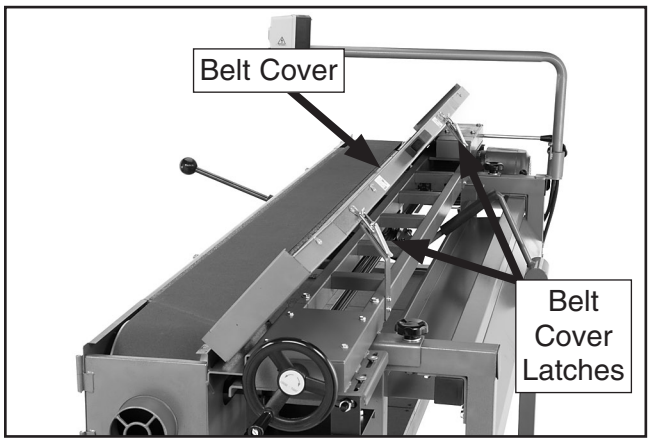


Figure 41. Belt cover latched open.

5. Remove the auxiliary workstops from the machine base and the table workstop from the table.

6. Make sure the belt pulley access doors are closed and secured.

7. Loosen the belt tilt lock handle and remove the two belt tilt lock knobs (**Figure 42**).

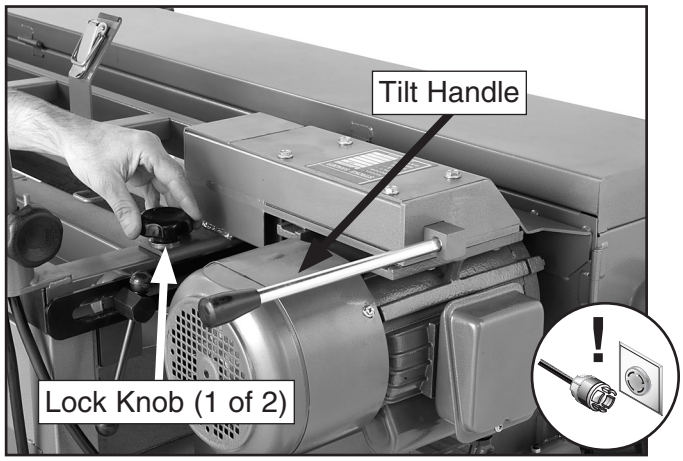


Figure 42. Tilt lock handle and lock knobs.

8. Use the belt tilt handle to tilt the entire belt assembly (**Figure 43**).

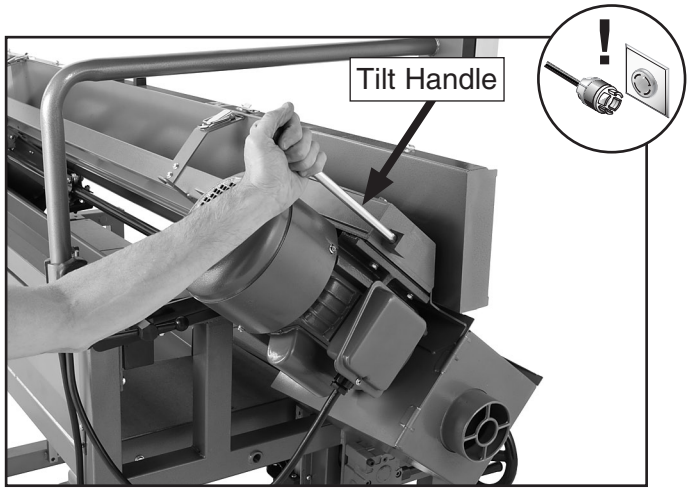


Figure 43. Tilting belt assembly.

9. Replace the belt tilt lock knobs into the edge sanding position (**Figure 44**).

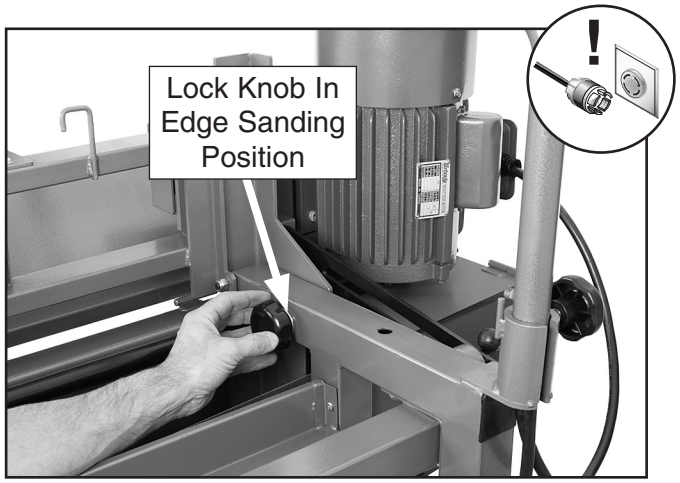


Figure 44. Lock knobs in edge sanding position.

10. Pull the table all the way forward, lock it in place with the table travel locks, then use the table elevation handwheel to raise the table until it is even with the belt (**Figure 45**).

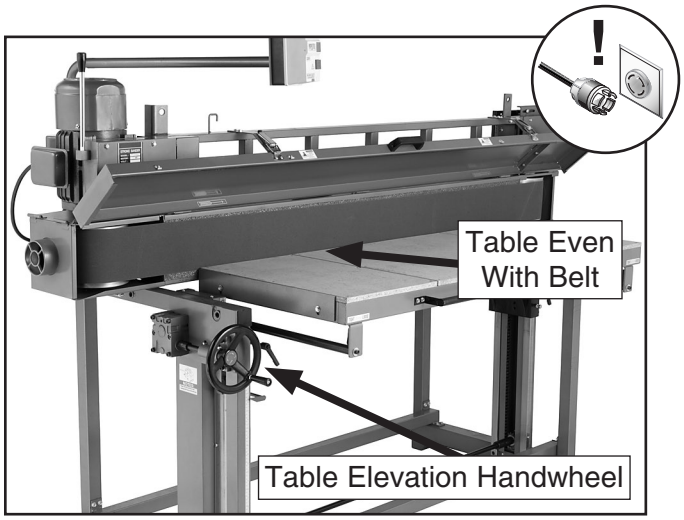


Figure 45. Elevating table.

NOTICE

If you try to raise the table to the top edge of the belt, the table and belt assembly will bind and may damage the machine. Do not attempt to force the table above the midline of the belt.

11. Position the table workstop on the right side of the table and the auxiliary work stops on the right side of the base.

Belt Replacement

Replacing the sanding belt on the Model G0679 is a simple process and is performed when the sanding belt becomes worn or when a sanding belt of a different grit is desired.

To replace the sanding belt:

1. DISCONNECT SANDER FROM POWER!

2. Use the belt tension handwheel to release tension from the belt.

3. Open the belt cover, drive wheel cover, and idler wheel cover (**Figure 46**).

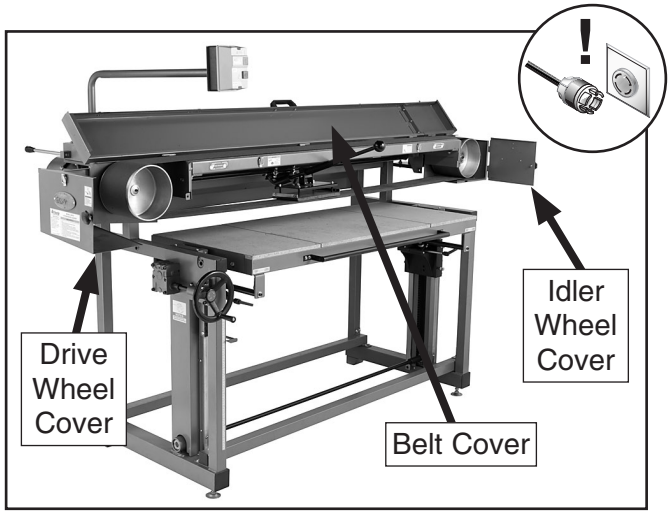


Figure 46. Belt covers open.

4. Slide the belt off of one of the wheels first, then remove the belt entirely.

5. Place the new sanding belt over one of the wheels, making sure the belt direction is correct.

6. Place the belt along the top platen, under the platen press, and over the other wheel, as shown in **Figure 47**.

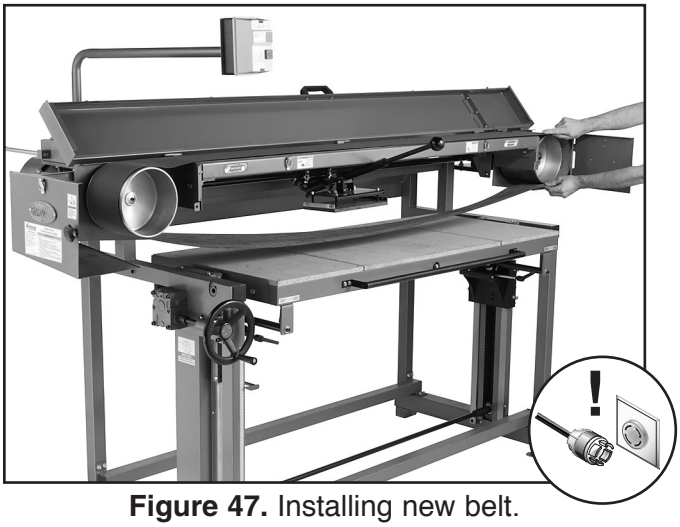


Figure 47. Installing new belt.

7. Center the belt over both wheels, then close the drive wheel and idler wheel covers.

8. Tension the belt so that the belt sags less than ½" across its length, then check the belt tracking, as described in **Belt Tracking** on **Page 36.**

Platen Press Movement

A stroke sander is unique in that it uses a movable platen to apply sanding pressure to the workpiece. This allows a user to vary the amount of material removed over different areas of the workpiece.

The platen press moves in two different planes. Movement in the vertical plane allows for variations in the amount of pressure applied while movement in the horizontal plane allows the user to sand different areas of the workpiece. This horizontal movement, combined with the horizontal movement of the table allows the entire surface of large workpieces to be sanded (**Figures 48**).

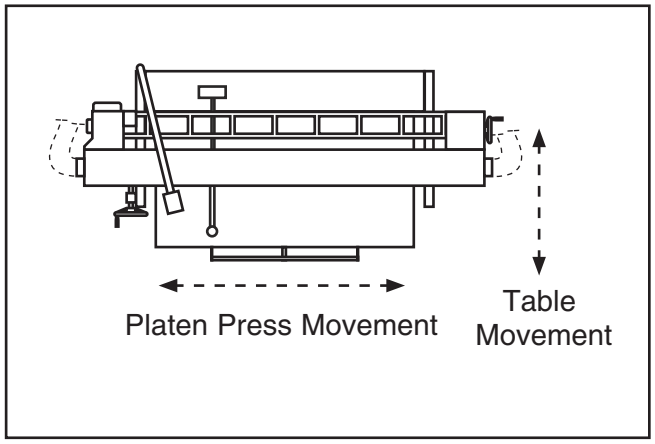


Figure 48. Sanding movements.

To move the platen press:

1. Pull the platen press handle down to apply pressure to the workpiece.

2. Slide the platen press handle side-to-side to move the platen press along the length of the workpiece.

To move the table:

1. Grasp the table handle.

2. Slide the table horizontally to move the workpiece across the width of the sanding belt.

Basic Operations

Stroke Sander

1. Place the workpiece on the table and against the table workstop.

   —If the workpiece is larger than the table, raise the table so that the workpiece hangs over the edge of the table above the uprights and against the auxiliary workstops.

2. Make sure the workstops are secure and that they will not move during operation.

3. Tension the sanding belt.

4. Raise the table until the workpiece is approximately ¼"–½" below the surface of the sanding belt.

5. Turn the machine ***ON***.

6. Grasp the platen press handle and pull it downward to apply sanding pressure to the workpiece. Move the platen press along the length of the workpiece. If your workpiece is wider than the width of the belt, use the table handle to move the table horizontally to sand across the width of the workpiece.

7. When the sanding is completed, turn the machine ***OFF***.

Edge Sander

1. Convert the machine to the edge sander mode. Make sure the table workstop and auxiliary workstops are positioned on the right side of the machine.

2. Place the workpiece on the table, against either the table workstop or the auxiliary workstops.

3. Turn the machine ***ON***.

4. Keeping the workpiece secure against the workstop, feed it towards the sanding belt.

5. When the sanding is completed, turn the machine ***OFF***.

SECTION 5: ACCESSORIES

T20501—Face Shield Crown Protector 4"
T20502—Face Shield Crown Protector 7"
T20503—Face Shield Window
T20448—Economy Clear Safety Glasses
T20452—"Kirova" Anti-Reflective Glasses
T20456—"Dakura" Clear Safety Glasses
H0736—Shop Fox® Safety Glasses
These glasses meet ANSI Z87.1-2003 specifications. Buy extras for visitors or employees. You can't be too careful with shop safety!

Figure 49. Our most popular eye protection.

T20514—Small Half-Mask Respirator
T20515—Medium Half-Mask Respirator
T20516—Large Half-Mask Respirator
T20511—Pre-Filter P100
T20539—Cartridge Filter 2PK P100
T20541—Cartridge Filter 2PK P100 & O Vapor
Wood and other types of dust can cause severe respiratory damage. If you work around dust everyday, a half-mask respirator can greatly reduce your risk. Compatible with safety glasses!

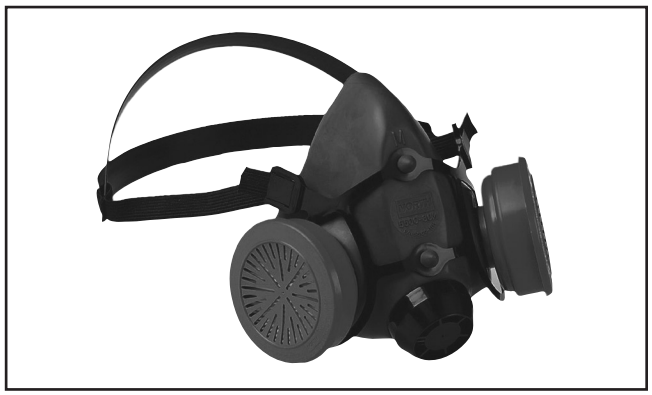


Figure 50. Half-mask respirator with disposable cartridge filters.

PRO-STICK® Abrasive Surface Cleaners
Extend the life of your sanding discs and sleeves! Choose the Pro-Stick® with a handle for greater control or without a handle for more usable area.

Size	Model
1½" X 1½" X 8½"	G1511
2" X 2" X 12"	G1512
1½" X 1½" X 9" with Handle	G2519
2" X 2" X 11" with Handle	G2520

Figure 51. PRO-STICK® abrasive cleaners.

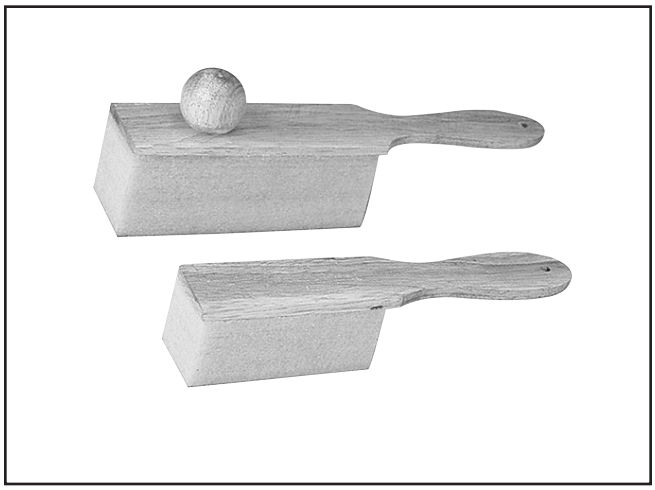


Figure 52. PRO-STICK® cleaners with handles.

Call 1-800-523-4777 To Order

G5443—6" x 186"; 60 Grit
G5444—6" x 186"; 80 Grit
G5445—6" x 186"; 100 Grit
G5446—6" x 186"; 120 Grit
G5447—6" x 186"; 150 Grit
G5548—6" x 186"; 180 Grit
G5549—6" x 186"; 220 Grit
These high quality "J" weight cloth-backed belts last longer and sand smoother!

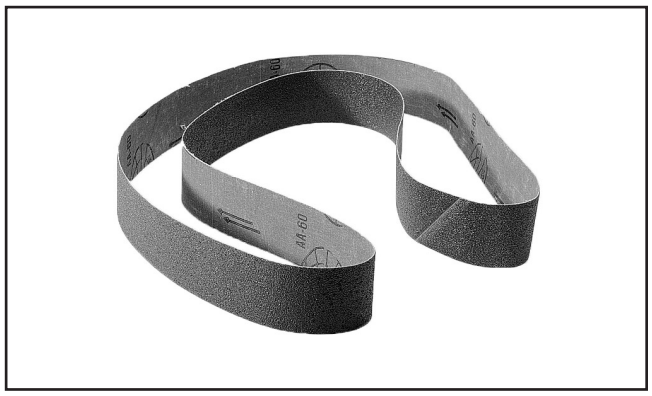


Figure 23. Replacement sanding belts.

H2443—Universal Adapter
This seven step adapter provides a multitude of dust collection reducing options. Simply cut away unneeded steps with a hacksaw. Outside diameter step sizes include 1", 2", 2.5", 3", 4", 5", and 6". Wall thickness is ⅛".

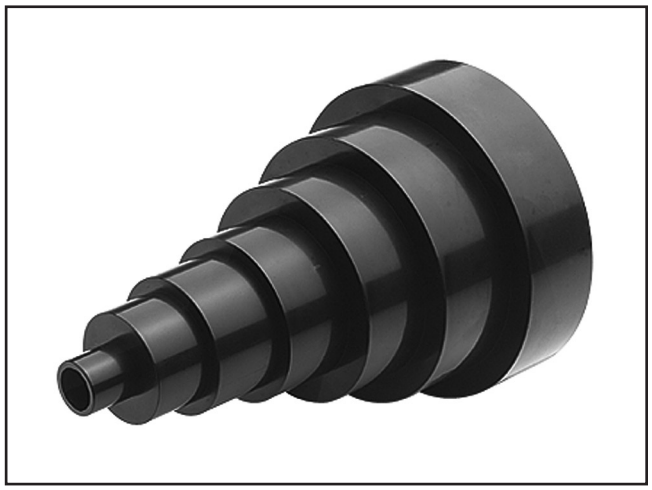


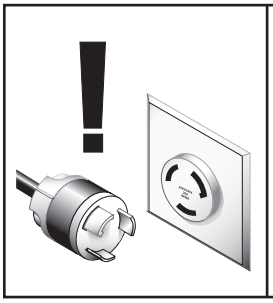
Figure 53. H2443 Universal Adapter.

G2752—4" Rolling Floor Sweep
G2753—4" Bench Dust Collection Attachment
G2754—4" Floor Dust Collection Attachment
These attachments are indispensable for collecting excess dust. The rolling floor sweep is also a convenient way to keep the shop floor or workbench top clean! Designed for use with 4" flexible hose (not included).

Figure 54. Dust collection attachments.

Call 1-800-523-4777 To Order

SECTION 6: MAINTENANCE



WARNING

Always disconnect power to the machine before performing maintenance. Failure to do this may result in serious personal injury.

Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily Check:
- Loose mounting bolts.
- Worn or damaged sanding belt.
- Worn or damaged wires.
- Any other unsafe condition.

Weekly Maintenance:
- Grease table elevation ways.
- Grease belt tension leadscrew.
- Oil table elevation chain.
- Clean/grease hold down shaft.

Every 500 Hours:
- Refill table elevation gearbox.

Cleaning

Cleaning the Model G0679 is relatively easy. Vacuum sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it.

Lubrication

Lubrication for the Model G0679 consists of greasing the table elevation ways, and belt tension leadscrew, oiling the table elevation chain, and refilling the table elevation gearbox.

Table Elevation Ways

Clean the table elevation ways with mineral spirits and a rag or brush to remove any grime. Dry the ways, then brush on a thin coat of light multi-purpose grease. Use the table elevation handwheel to move the table up and down several times to disperse the grease (**Figure 55**).

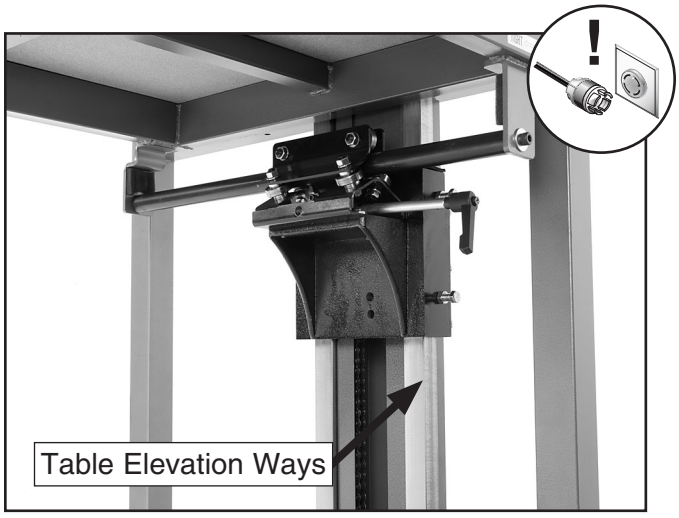


Figure 55. Table elevation ways.

Belt Tension Leadscrew

Clean the belt tension leadscrew with mineral spirits and a rag or brush to remove any grime. Dry the leadscrew, then brush on a thin coat of light multi-purpose grease. Use the belt tension handwheel to tighten and loosen the belt several times to disperse the grease (**Figure 56**).

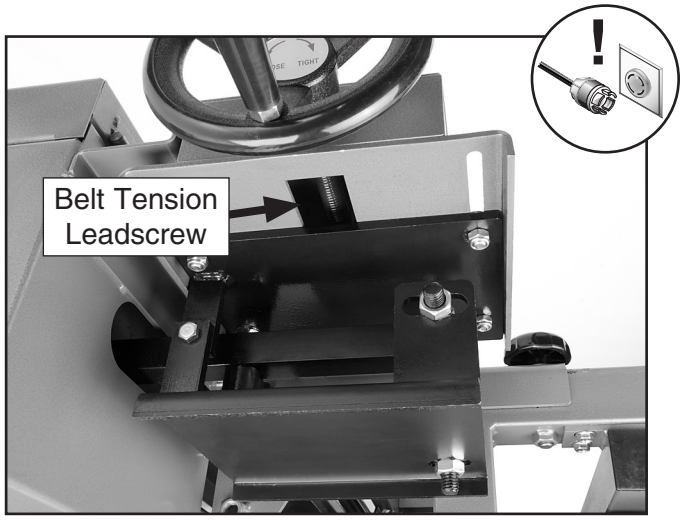


Figure 56. Belt tension leadscrew.

Table Elevation Chain

Clean the table elevation chain with mineral spirits and a rag or brush to remove any grime. To ensure complete cleaning of the chain, raise and lower the table to expose the entire length of chain. Dry the chain, then spray on a chain lubricant. Raise and lower the table several times to disperse the lubricant (**Figure 56**).

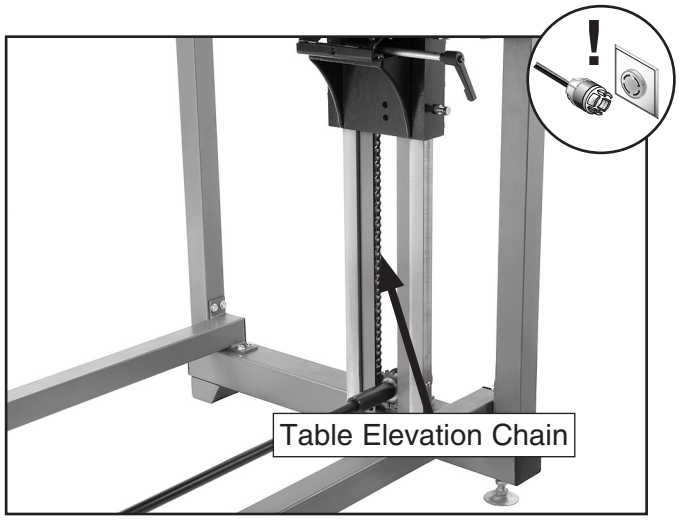


Figure 56. Table elevation chain.

Table Elevation Gearbox

After every 500 hours of use, the table elevation gearbox must be refilled. Use a rag to clean any grime from around the filler plug, then remove the filler plug and use a manual oiler to add oil until the gearbox is full. Replace the filler plug (**Figure 57**).

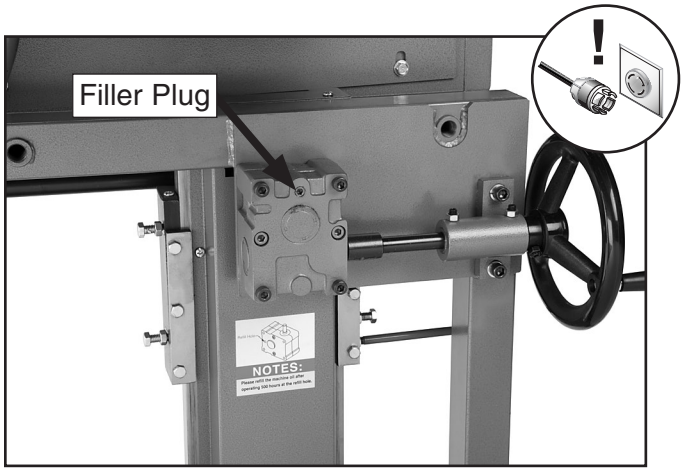
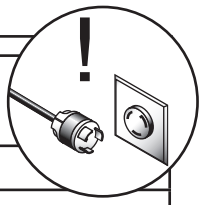


Figure 57. Table elevation gearbox.

SECTION 7: SERVICE

Review the troubleshooting and procedures in this section to fix or adjust your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, then feel free to call our Technical Support at (570) 546-9663.

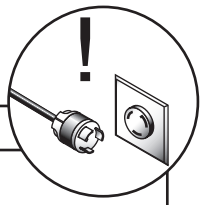
Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	1. Power supply switched OFF or is at fault.	1. Ensure power supply is switched on; ensure power supply has the correct voltage.
	2. Start capacitor is at fault.	2. Test/replace if faulty.
	3. Motor connection wired incorrectly.	3. Correct motor wiring connections (**Page 38**).
	4. Wall fuse/circuit breaker is blown/tripped.	4. Ensure circuit size is suitable for this machine; replace weak breaker.
	5. Wiring is open/has high resistance.	5. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary.
	6. Motor ON/OFF switch is at fault.	6. Replace faulty ON/OFF switch.
Machine stalls or is overloaded.	1. Motor connection is wired incorrectly.	1. Correct motor wiring connections (**Page 38**).
	2. Motor bearings are at fault.	2. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
	3. Motor has overheated.	3. Clean off motor, let cool, and reduce workload.
	4. Motor is at fault.	4. Test/repair/replace.
Machine has vibration or noisy operation.	1. Motor or component is loose.	1. Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread locking fluid.
	2. Motor mount loose/broken/incorrect.	2. Tighten/replace/adjust.
	3. Motor fan is rubbing on fan cover.	3. Replace dented fan cover; replace loose/damaged fan.
	4. Motor bearings are at fault.	4. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.

Operations



Symptom	Possible Cause	Possible Solution
Machine vibrates excessively (non-motor related).	1. Stand not stable on floor. 2. Incorrect sanding belt tension. 3. Broken/defective sanding belt.	1. Level machine. 2. Make sure tension is correct (**Page 27**). 3. Replace sanding belt (**Page 27**).
Sanded surface not square.	1. Table not perpendicular to belt.	1. Adjust 90° stop (**Page 35**).
Deep sanding grooves or scores in workpiece.	1. Sandpaper too coarse for the desired finish. 2. Workpiece sanded across the grain. 3. Too much sanding force on workpiece. 4. Workpiece held still against the belt.	1. Use a finer grit sanding belt. 2. Sand with the grain. 3. Reduce pressure on workpiece while sanding. 4. Keep workpiece moving while sanding on the belt.
Abrasive grit rubs off the belt easily.	1. Sanding belt has been stored in an incorrect environment. 2. Sanding belt has been folded or smashed.	1. Store sanding belt away from extremely dry/hot or damp/wet temperatures. 2. Store sanding belt flat, not folded or bent.
Sanding belt surface clogs quickly or burn.	1. Too much pressure applied to workpiece. 2. Sanding softwood. 3. Sanding belt grit too fine.	1. Reduce pressure on workpiece while sanding. 2. Use different stock. Or, accept the characteristics of the stock and plan on cleaning/replacing belts frequently. 3. Use coarser grit sanding belt.
Burn marks on workpiece.	1. Using too fine of sanding grit. 2. Using too much pressure. 3. Platen press/workpiece held still for too long.	1. Use a coarser grit sanding belt. 2. Reduce pressure on workpiece while sanding. 3. Do not keep platen press/workpiece in one place for too long.
Glazed sanding surfaces.	1. Sanding wet stock. 2. Sanding stock with high residue.	1. Dry stock properly before sanding. 2. Use different stock. Or, accept the characteristics of the stock and plan on cleaning/replacing belts frequently.
Belt rubs on machine frame.	1. Tracking incorrect.	1. Adjust belt tracking (**Page 36**).

Table Bearings

The table rolls forward and backwards on bearing assemblies. If you notice excessive vertical play in the table, you may need to adjust the bearing assemblies.

The bearings are mounted on eccentric shafts. By rotating the shaft, the position of the bearings is moved up or down. To remove excessive play, it is only necessary to adjust the top two bearings on each side of the table.

Tools Needed	Qty
Wrench 14mm	1
Standard Screwdriver	1

To adjust the bearing assemblies:

1. Loosen the hex nuts on each end of the bearing shafts. It is not necessary to fully remove them (**Figure 58**).

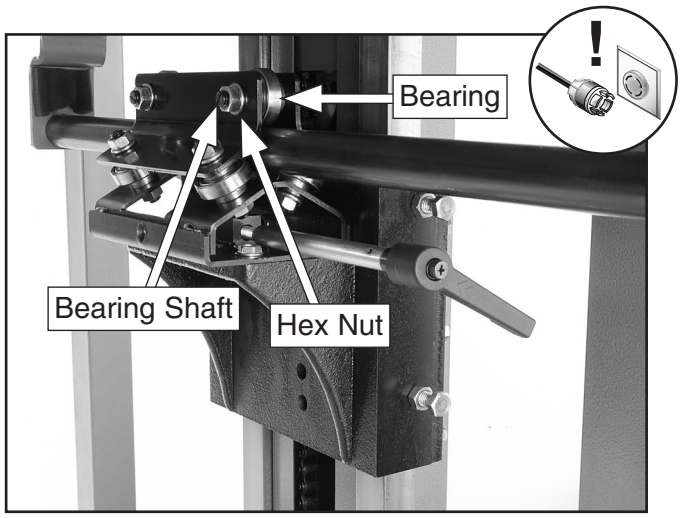


Figure 58. Table bearing adjustment.

2. Use a standard screwdriver to rotate the bearing shaft. You will see the bearing moving inward or outward relative to the table rod. Rotate the shaft so that the bearing is snug against the table rod.

3. Without rotating the shaft, tighten the hex nuts.

4. Repeat **Steps 1–3** for the other three bearing shafts.

90° Stop

The Model G0679 is equipped with an adjustable 90° stop to ensure that the belt is perpendicular to the table when converted to the edge sanding mode. If the belt is not 90° to the table, this stop can be adjusted.

To adjust the 90° stop:

1. DISCONNECT SANDER FROM POWER!

2. Convert the sander to the edge sanding mode, if it is not already.

3. Use a square to check the angle between the belt and the table at both ends of the machine (**Figure 59**).

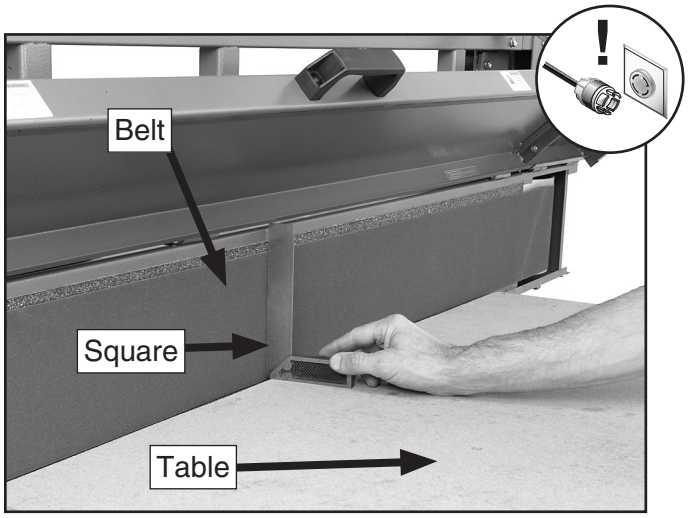


Figure 59. Checking belt for square.

—If the belt is square at both ends, no adjustment is needed.

—If the belt is not square at both ends, proceed with these instructions.

4. Lower the belt cover, as shown in **Figure 60,** to gain access to the 90° stop screws. Loosen the jam nut several turns so that the cap screw can turn freely.

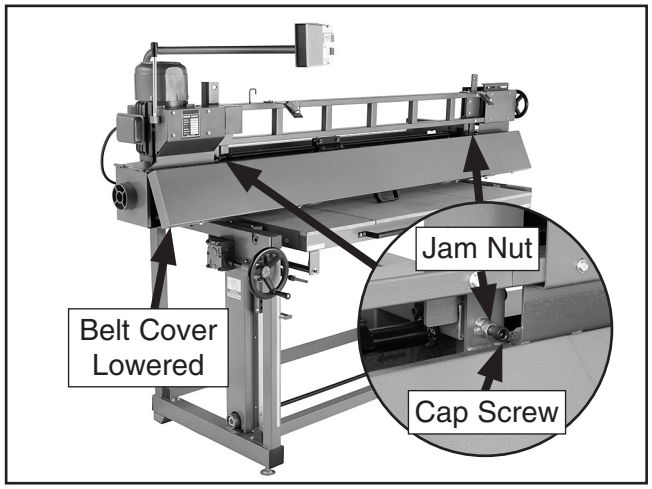


Figure 60. Jam nut and cap screw.

5. Adjust the cap screw as needed until the belt is square to the table. Lift the belt cover as needed to access the belt surface.

6. Without turning the cap screw, tighten the jam nut.

7. Repeat **Steps 4–6** on the other 90° stop.

8. Re-check for square, and repeat **Steps 4–7**, as necessary until the setting meets your standards.

Belt Tracking

The sanding belt tracking on the Model G0679 can be adjusted to make sure the belt travels smoothly between the drive and idler wheels without rubbing on the sides of the platen assembly.

Tools Needed	**Qty**
Safety Glasses	1 Pair
Wrench 19mm	1

To adjust the sanding belt tracking:

1. Open the belt cover.

2. Loosen the outer belt tracking nut (**Figure 61**)

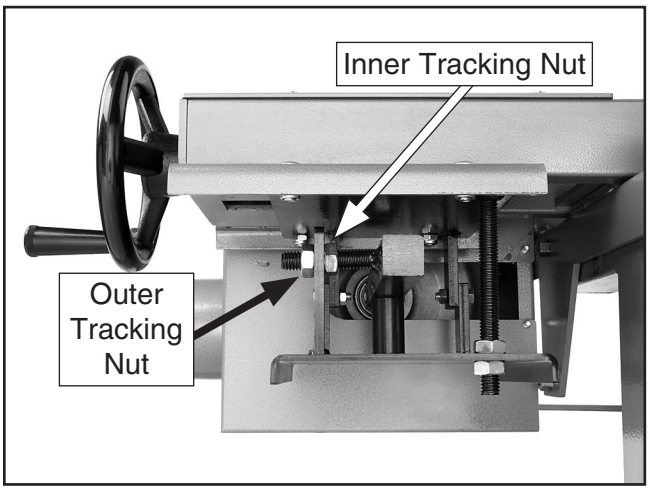


Figure 61. Belt tracking adjustment.

3. While wearing safety glasses, turn the sander ***ON***.

4. Turn the inner nut as needed until the belt is centered on the drive and idler wheels, then tighten the outer nut.

5. Make sure the belt is still tracking properly.

   —If the belt is tracking properly, no further adjustment is needed.

   —If the belt is no longer tracking properly, repeat **Steps 4–5** until the tracking is correct.

6. Turn the sander ***OFF***.

Table Elevation Wear Pin Adjustment

The table travels vertically along the table elevation ways. A series of wear pins reduce friction between the table brackets and elevation ways, making it easier to move the table up and down. Over time, these pins will wear, resulting in slop between the table brackets and elevation ways. To compensate for this wear, the wear pins can be adjusted.

Tools Needed	**Qty**
Wrench 14mm	1

To adjust the wear pins:

1. DISCONNECT SANDER FROM POWER!

2. Loosen the jam nut shown in (**Figure 62**).

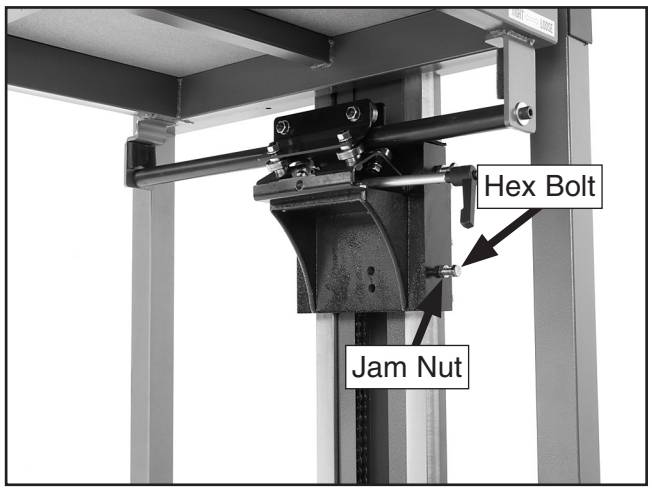


Figure 62. Wear pin adjustment.

3. Tighten the hex bolt until you just begin to feel resistance.

—The goal is to position the wear pins against the ways without applying pressure to the them. The ideal setting will allow easy, slop-free horizontal movement of the table.

4. When you are satisfied with the positioning of the hex bolt, keep it from turning and fully tighten the jam nut.

5. Repeat **Steps 2–4** with the remaining seven wear pins.

SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Study this section carefully. If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine.

⚠WARNING
Wiring Safety Instructions

1. **SHOCK HAZARD.** Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!

2. **CIRCUIT REQUIREMENTS.** You MUST follow the requirements on **Page 9** when connecting your machine to a power source.

3. **QUALIFIED ELECTRICIAN.** Due to the inherent hazards of electricity, only a qualified electrician should perform wiring tasks on this machine. If you are not a qualified electrician, get help from one before attempting any kind of wiring job.

4. **WIRE CONNECTIONS.** All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

5. **MODIFICATIONS.** Using aftermarket parts or modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire.

6. **MOTOR WIRING.** The motor wiring shown in these diagrams is current at the time of printing, but it may not match your machine. Always use the wiring diagram inside the motor junction box.

7. **WIRE/COMPONENT DAMAGE.** Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components before completing the task.

8. **CAPACITORS.** Some capacitors store an electrical charge for up to five minutes after being disconnected from the power source. To avoid being shocked, wait at least this long before working on capacitors.

9. **EXPERIENCING DIFFICULTIES.** If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (570) 546-9663.

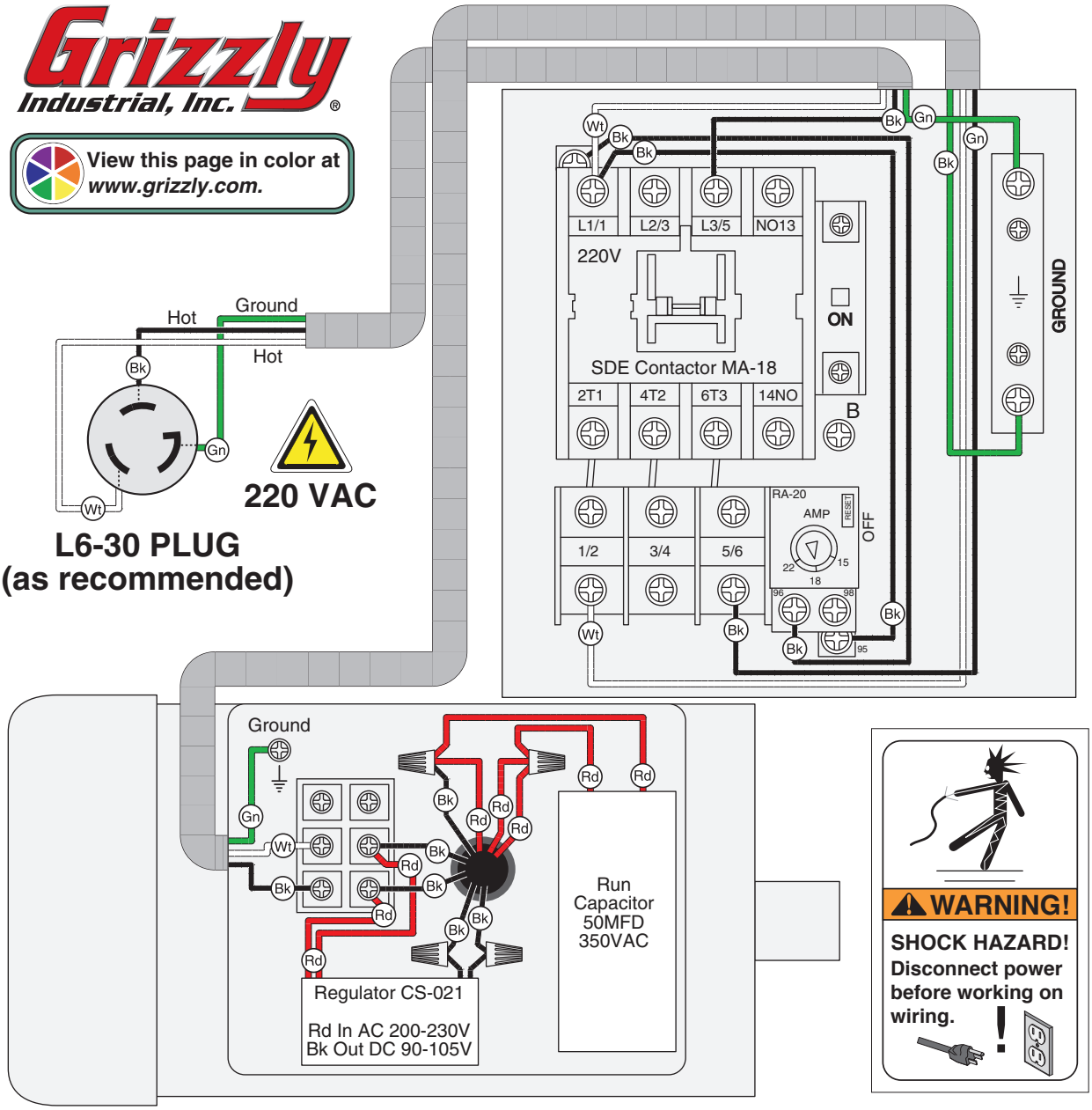
NOTICE

The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

BLACK	Bk	BLUE	Bl	YELLOW	Yl	LIGHT BLUE	Lb
WHITE	Wt	BROWN	Br	YELLOW GREEN	Yg	BLUE WHITE	Bw
GREEN	Gn	GRAY	Gy	PURPLE	Pu	TURQUOISE	Tu
RED	Rd	ORANGE	Or	PINK	Pk		

Wiring Diagram



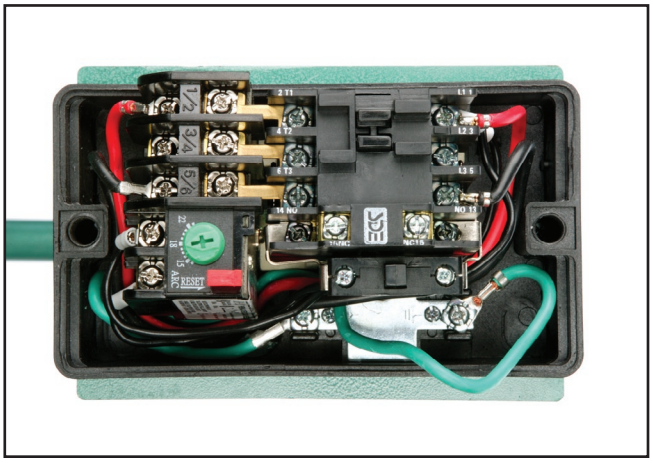


Figure 63. Switch wiring.

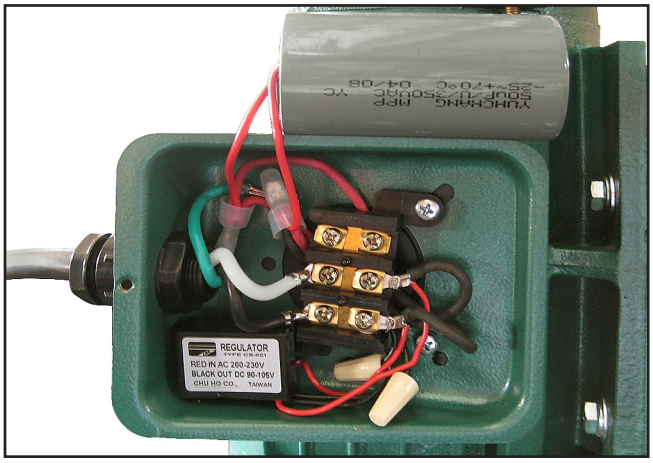
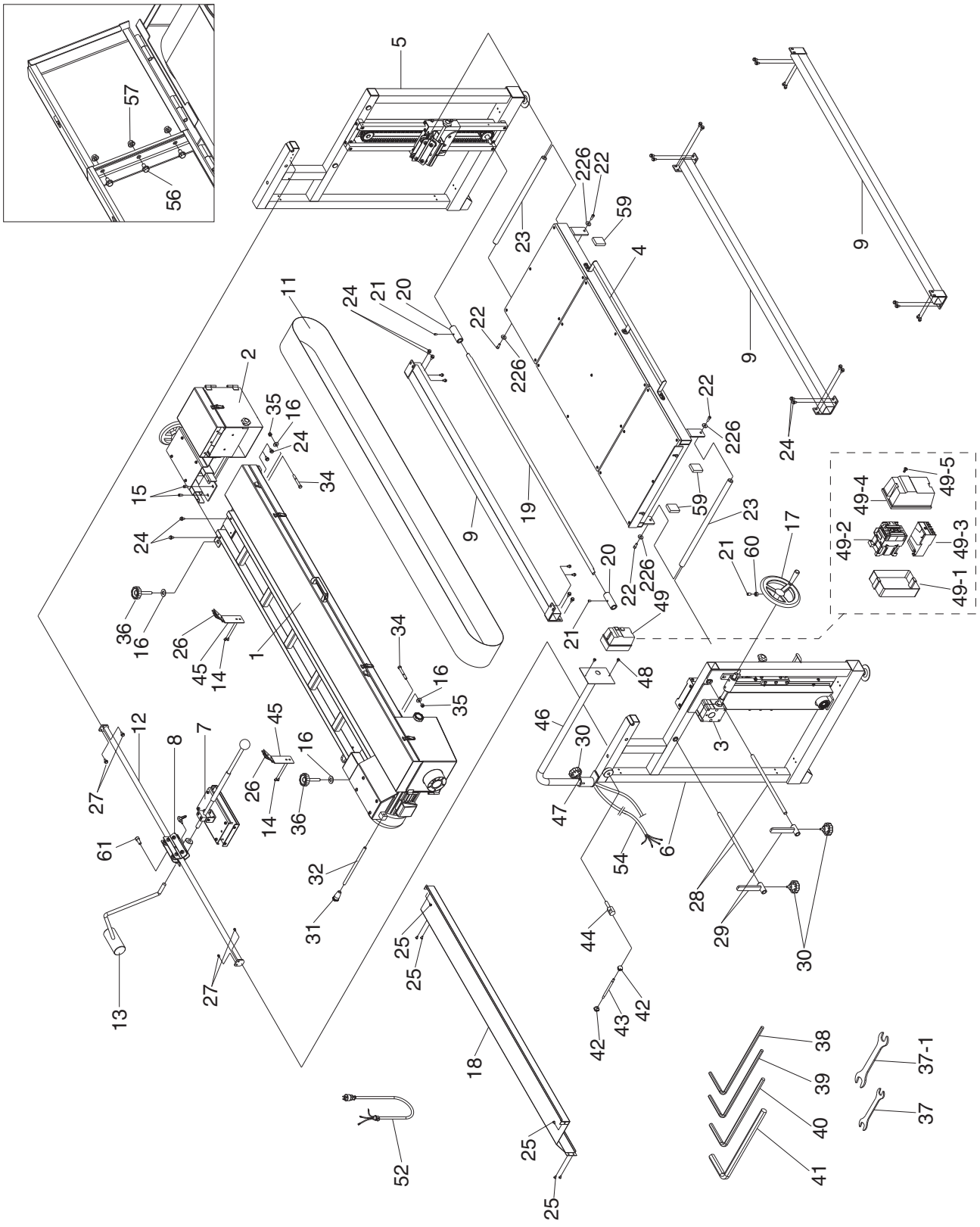


Figure 64. Motor wiring.

SECTION 9: PARTS

Main Breakdown

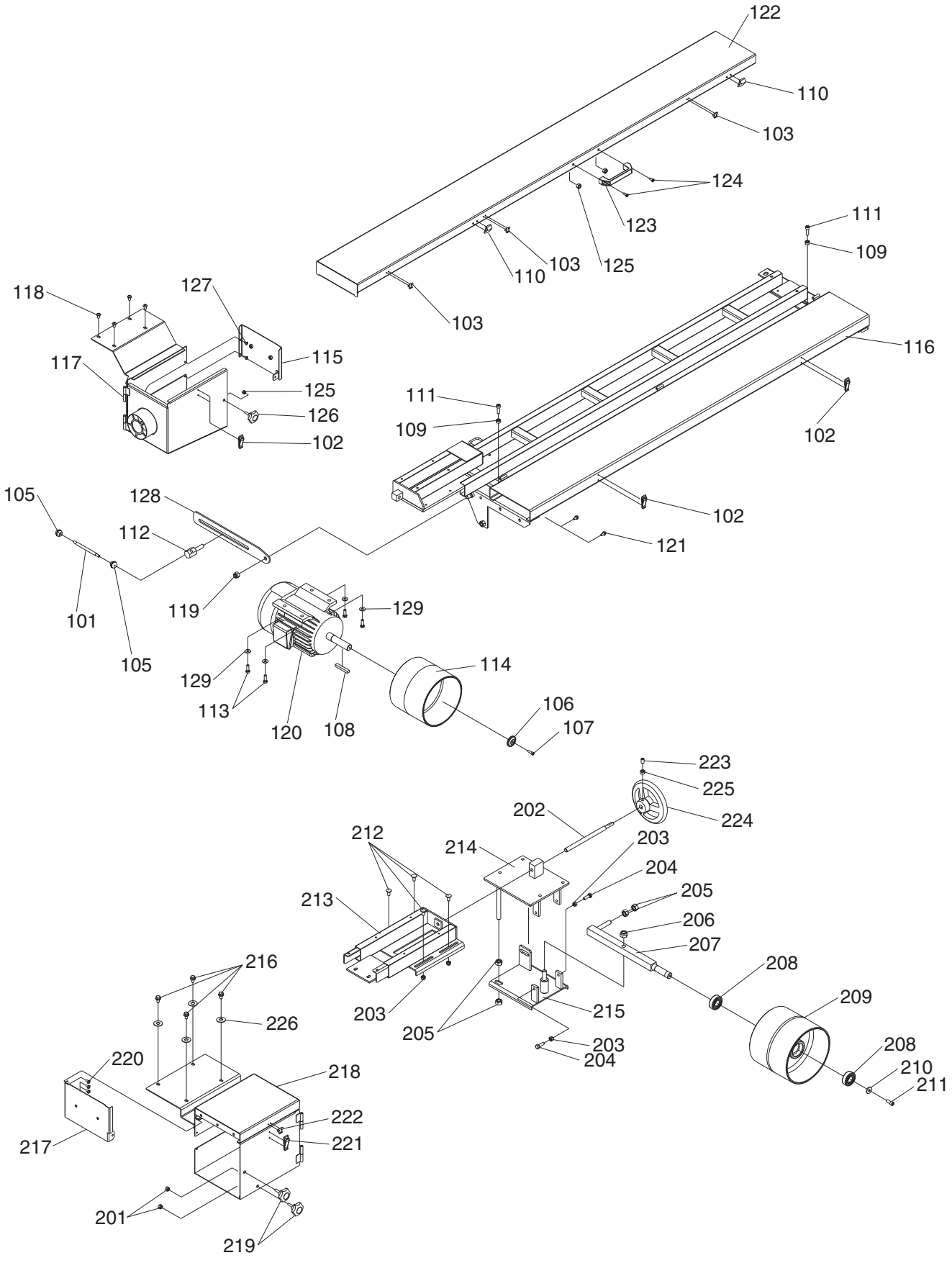


Main Parts List

REF	PART #	DESCRIPTION
1	P0679001	BELT PLATE ASSEMBLY
2	P0679002	FRONT BELT PLATE ASSEMBLY
3	P0679003	GEAR BOX ASSEMBLY
4	P0679004	TABLE ASSEMBLY
5	P0679005	RIGHT UPRIGHT ASSEMBLY
6	P0679006	LEFT UPRIGHT ASSEMBLY
7	P0679007	PLATEN ASSEMBLY
8	P0679008	PLATEN PRESS ASSEMBLY
9	P0679009	CONNECTING TUBE
10	PS06	PHLP HD SCR 10-24 X 3/8
11	P0679011	SANDING BELT 100 GRIT
12	P0679012	PLATEN ASSEMBLY ROD
13	P0679013	COUNTERWEIGHT
14	PFB03	FLANGE BOLT 1/4-20 X 1/2
15	PFB01	FLANGE BOLT 5/16-18 X 1/2
16	PW01	FLAT WASHER 1/2
17	P0679017	HANDWHEEL
18	P0679018	COVER
19	P0679019	CHAIN CONNECTING ROD
20	P0679020	CONNECTING ROD CAP
21	PSS17	SET SCREW 5/16-18 X 5/16
22	PSB07	CAP SCREW 5/16-18 X 3/4
23	P0679023	TABLE SPINDLE
24	PFB01	FLANGE BOLT 5/16-18 X 1/2
25	PS07	PHLP HD SCR 1/4-20 X 3/8
26	P0679026	BELT COVER CLAMP
27	PB19	HEX BOLT 1/4-20 X 1/2
28	P0679028	COVER SPINDLE
29	P0679029	TUBE CAP
30	PSW03-1	KNOB 5/16-18 X 3/4
31	P0679031	LEVER KNOB 1/2-12
32	P0679032	LEVER

REF	PART #	DESCRIPTION
34	P0679034	SHOULDER SCREW 1/2-13 X 3
35	PLN06	LOCK NUT 1/2-13
36	P0679036	LOCK KNOB 1/2-12 X 2-3/4
37	PWR1214	COMBO WRENCH 12/14MM
37-1	PWR1719	WRENCH 17 X 19
38	PAW04M	HEX WRENCH 4MM
39	PAW05M	HEX WRENCH 5MM
40	PAW06M	HEX WRENCH 6MM
41	PAW08M	HEX WRENCH 8MM
42	P0679042	BALL HANDLE 1/2-12
43	P0679043	ROD
44	P0679044	ANGLE SPINDLE
45	P0679045	COVER FIXING PLATE
46	P0679046	SWITCH SUPPORT
47	PSB04	CAP SCREW 1/4-20 X 1/2
48	PS08	PHLP HD SCR 10-24 X 3/4
49	P0679049	MAGNETIC SWITCH 3HP 220V 1-PH
49-1	P0679049-1	SWITCH BASE
49-2	P0679049-2	CONTACTOR SDE MA-18
49-3	P0679049-3	OVERLOAD RELAY RA-20
49-4	P0679049-4	SWITCH COVER
49-5	P0679049-5	PLASTIC SCREW
51	PN07	HEX NUT 10-24
52	P0679052	MOTOR CORD
54	P0679054	POWER CORD
56	PFB03	FLANGE BOLT 1/4-20 X 1/2
57	PN05	HEX NUT 1/4"-20
59	P0679059	FOAM PAD
60	PN02	HEX NUT 5/16"-18
61	PSB07	CAP SCREW 5/16-18 X 3/4
226	PW07	FLAT WASHER 5/16

Belt & Idler Wheel Assembly Breakdown

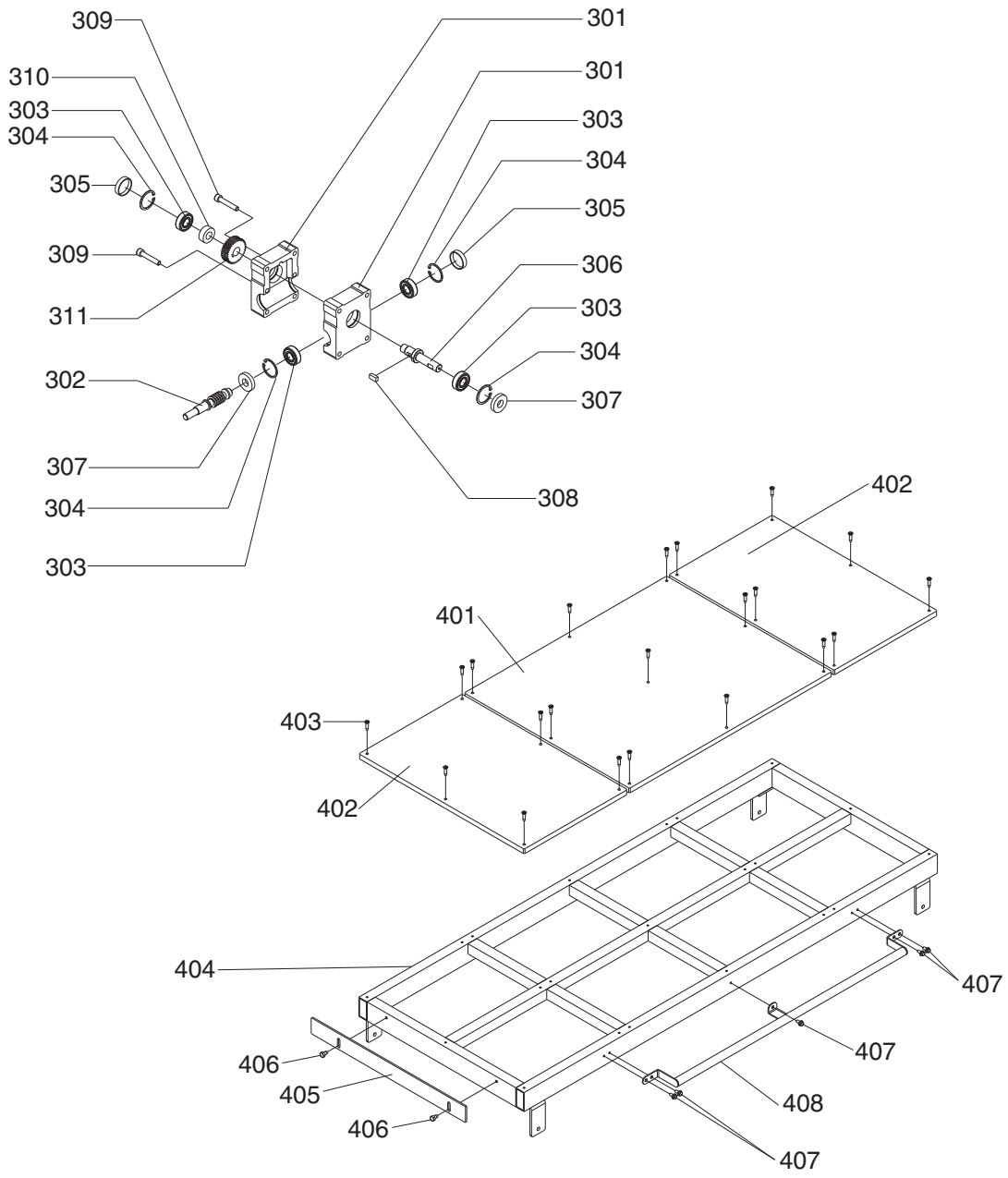


Belt Assembly Parts List

REF	PART #	DESCRIPTION
101	P0679101	BAR
102	P0679102	CLAMP (SMALL)
103	P0679103	HOOK (SMALL)
105	P0679105	BALL HANDLE
106	P0679106	FLANGE WASHER
107	PSB02M	CAP SCREW M6-1 X 20
108	P0679108	KEY 7 X 7 X 75
109	PN08	HEX NUT 3/8-16
110	P0679110	HOOK (BIG)
111	PSB19	CAP SCREW 3/8-16 X 1-1/4
112	P0679112	CONNECTOR 1/2-12 X 1-3/4
113	PB03	HEX BOLT 5/16-18 X 1
114	P0679114	DRIVING WHEEL
115	P0679115	LEFT COVER BOARD
116	P0679116	BELT PLATE
117	P0679117	DRIVING WHEEL COVER
118	PS38	PHLP HD SCR 5/16-18 X 1/2
119	PLN06	LOCK NUT 1/2-12
120	P0679120	MOTOR 3HP 220V 1-PH
121	PFB01	FLANGE BOLT 5/16-18 X 1/2
122	P0679122	COVER
123	P0679123	HANDLE (BIG)
124	PS02	PHLP HD SCR 1/4-20 X 3/4
125	PLN02	LOCK NUT 1/4-20
126	P0679126	KNOB 1/4-20 X 5/8
127	PS07	PHLP HD SCR 1/4-20 X 3/8
128	P0679128	TILT LOCK BRACKET

REF	PART #	DESCRIPTION
129	PLW01	LOCK WASHER 5/16
201	PLN02	LOCK NUT 1/4-20
202	P0679202	ADJUSTABLE SPINDLE
203	PLN03	LOCK NUT 5/16-18
204	PB09	HEX BOLT 5/16-18 X 1/2
205	PN41	HEX NUT 1/2"-12
206	P0679206	SPECIAL NUT 1/2-13
207	P0679207	DRIVING WHEEL SPINDLE
208	P6204	BALL BEARING 6204ZZ
209	P0679209	IDLER WHEEL
210	P0679210	DRUM WASHER
211	PSB07	CAP SCREW 5/16-18 X 3/4
212	PCB05	CARRIAGE BOLT 5/16-18 X 3/4
213	P0679213	FRONT BELT PLATE
214	P0679214	UPPER ADJUSTABLE SET
215	P0679215	LOWER ADJUSTABLE SET
216	PFB03	FLANGE BOLT 1/4-20 X 1/2
217	P0679217	RIGHT COVER
218	P0679218	DRIVING WHEEL COVER
219	P0679219	LOCK KNOB 1/4-20
220	PS07	PHLP HD SCR 1/4-20 X 3/8
221	P0679221	CLAMP (SMALL)
222	P0679222	HOOK (SMALL)
223	PSS01	SET SCREW 5/16-18 X 1
224	P0679224	HANDWHEEL
225	PN02	HEX NUT 5/16"-18
226	PW07	FLAT WASHER 5/16

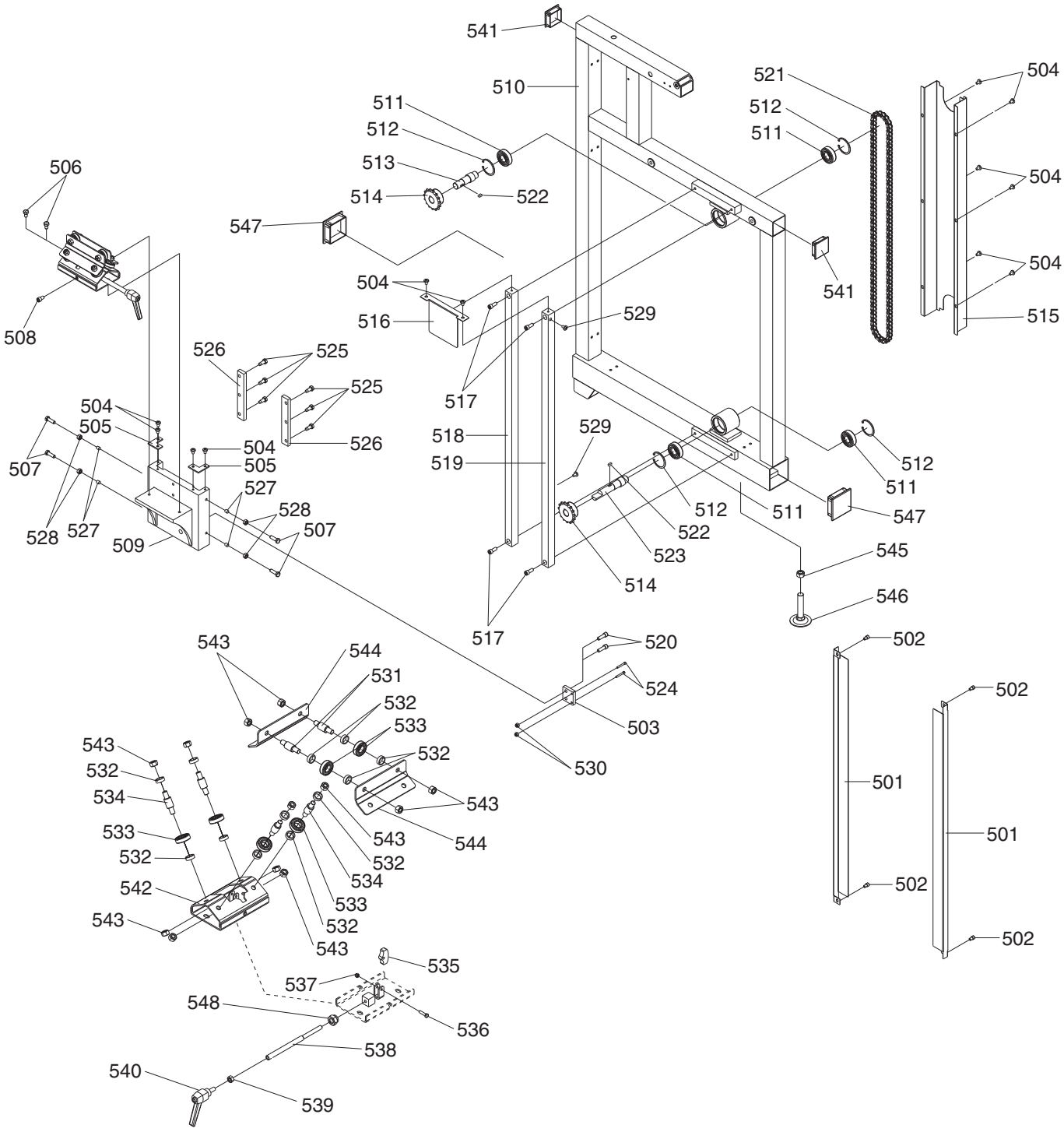
Gearbox & Table Breakdown & Parts List



REF	PART #	DESCRIPTION
301	P0679301	GEAR BOX
302	P0679302	WORM SHAFT
303	P6202	BALL BEARING 6202ZZ
304	PR21M	INT RETAINING RING 35MM
305	P0679305	REAR BUSHING
306	P0679306	GEAR SPINDLE
307	P0679307	FRONT BUSHING
308	P0679308	KEY 7 X 7 X 16
309	PSB08	CAP SCREW 5/16-18 X 1-1/2
310	P0679310	ALUMINUM SPACER

REF	PART #	DESCRIPTION
311	P0679311	WORM GEAR
401	P0679401	WOOD BOARD (LONG)
402	P0679402	WOOD BOARD (SHORT)
403	PFH12	FLAT HD SCR 1/4-20 X 1
404	P0679404	TABLE FRAME
405	PB09	TABLE WORK STOP
406	PB09	HEX BOLT 5/16-18 X 1/2
407	PFB03	FLANGE BOLT 1/4-20 X 1/2
408	P0679408	HANDLE (BIG)

Right Upright Assembly Breakdown

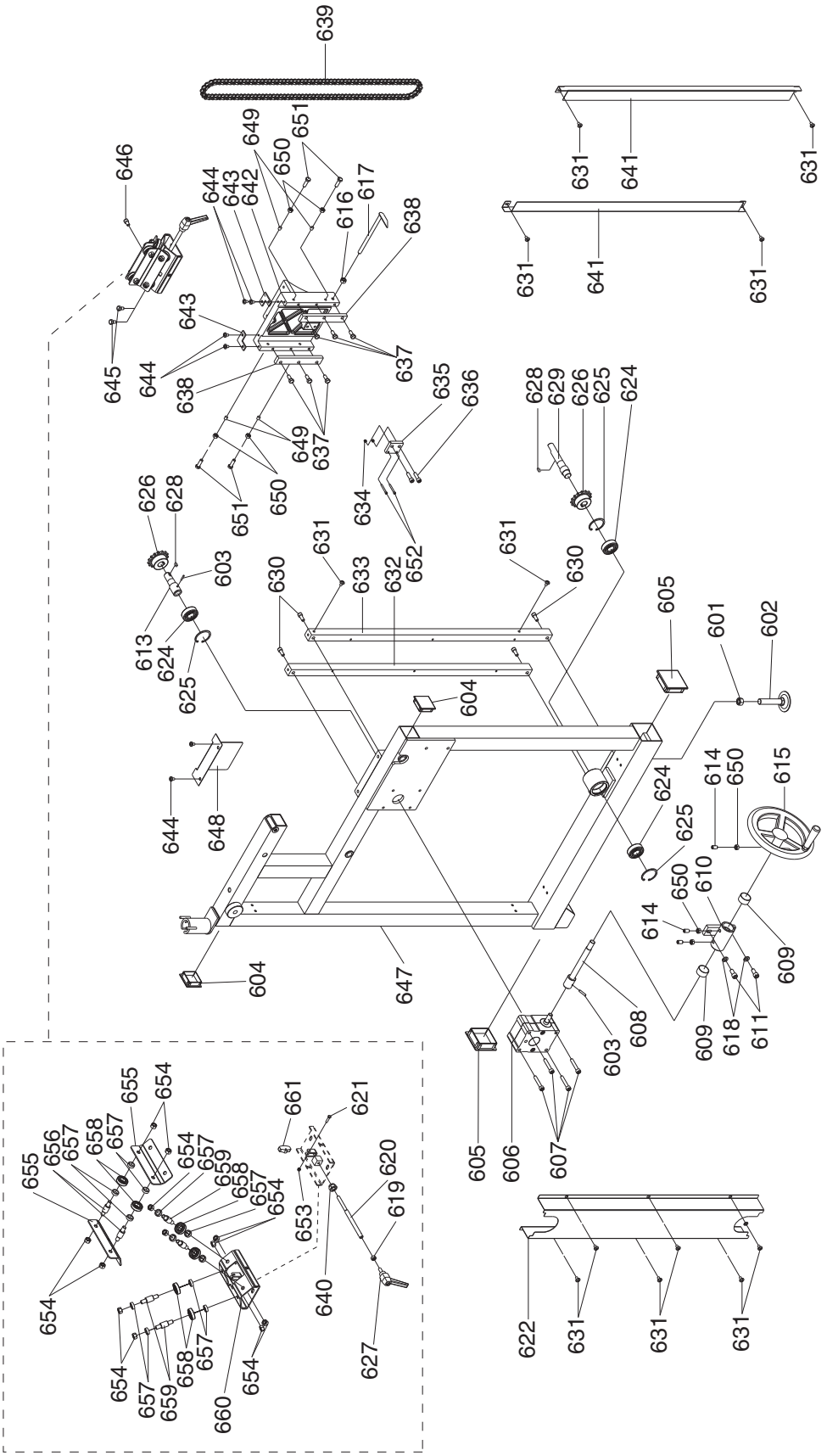


Right Upright Assembly Parts List

REF	PART #	DESCRIPTION
501	P0679501	CHAIN COVER
502	PSB17	CAP SCREW 1/4-20 X 3/8
504	PS07	PHLP HD SCR 1/4-20 X 3/8
505	P0679505	L-PLATE
506	PB09	HEX BOLT 5/16-18 X 1/2
507	PB03	HEX BOLT 5/16-18 X 1
508	PSB30	CAP SCREW 5/16-18 X 1/2
509	P0679509	COVER
510	P0679510	RIGHT SUPPORT FOOT
511	P0679511	BALL BEARING 6240ZZ
512	PR25M	INT RETAINING RING 47MM
513	P0679513	CHAIN WHEEL ADAPTER
514	P0679514	SPROCKET
515	P0679515	CHAIN COVER
516	P0679516	DUST COVER
517	PSB07	CAP SCREW 5/16-18 X 3/4
518	P0679518	GEAR BAR (RIGHT)
519	P0679519	GEAR BAR (LEFT)
520	PSB03	CAP SCREW 5/16-18 X 1
521	P0679521	CHAIN
522	PK06M	KEY 5 X 5 X 10
523	P0679523	CHAIN TRANSMITTING SPINDLE
524	P0679524	CAP SCREW #8-32 X 1
525	PB07	HEX BOLT 5/16-18 X 3/4

REF	PART #	DESCRIPTION
526	P0679526	TRACKING BOARD
527	P0679527	COPPER WEAR PIN
528	PN02	HEX NUT 5/16"-18
529	PS09	PHLP HD SCR 1/4-20 X 1/4
530	P0679530	LOCK NUT #8-32
531	P0679531	ECCENTRIC SPACER
532	P0679532	CAP
533	P6002	BALL BEARING 6002ZZ
534	P0679534	ADAPTER
535	P0679535	SPINDLE FIXING BOARD
536	P0679536	SPECIAL BOLT M5-.8 X 20
537	PFN04M	FLANGE NUT M5-.8
538	P0679538	ADJUSTABLE LOCKING ROD
539	PN03M	HEX NUT M8-1.25
540	P0679540	LOCK HANDLE M4-.7 X 13
541	P0679541	SQUARE CAP
542	P0679542	TRACKING SET (RIGHT)
543	PN08	HEX NUT 3/8-16
544	P0679544	BRACKET
545	PN41	HEX NUT 1/2"-12
546	P0679546	FOOT PAD
547	P0679547	CAP
548	PLN03	LOCK NUT 5/16-18

Left Upright Assembly Breakdown

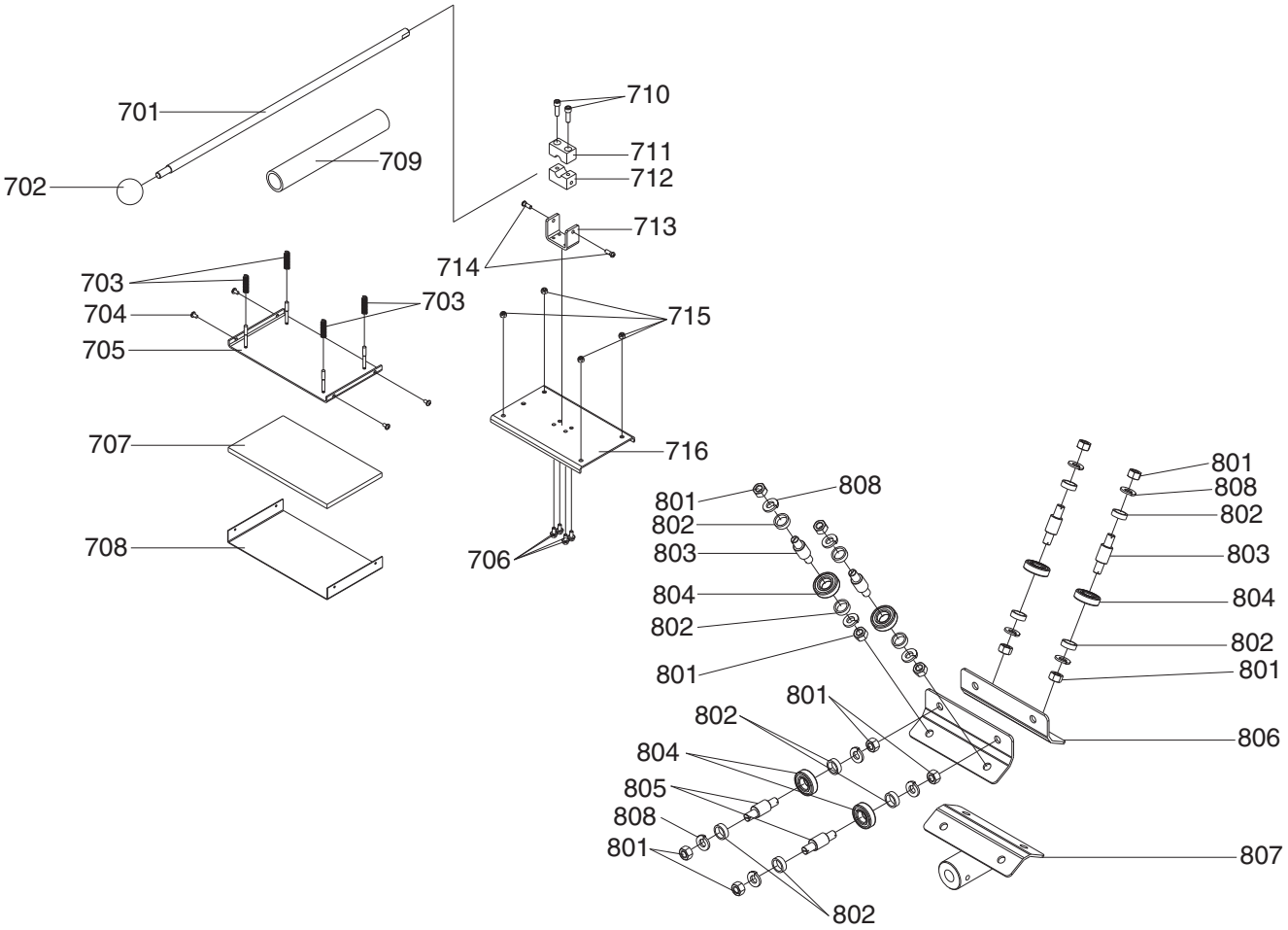


Left Upright Assembly Parts List

REF	PART #	DESCRIPTION
601	PN41	HEX NUT 1/2"-12
602	P0679602	FOOT PAD
603	P0679603	SPECIAL PIN
604	P0679604	SQUARE CAP
605	P0679605	CAP
606	P0679606	GEAR BOX
607	PSB148M	CAP SCREW M8-1.25 X 80
608	P0679608	HANDWHEEL SPINDLE
609	P0679609	COPPER TUBE
610	P0679610	HANDWHEEL ASSEMBLY
611	PSB16	CAP SCREW 3/8-16 X 3/4
613	P0679613	GEAR BOX SPINDLE
614	PSS08	SET SCREW 5/16-18 X 1/2
615	P0679615	HANDWHEEL
616	PN08	HEX NUT 3/8"-16
617	P0679617	INDICATOR
618	PLW04	LOCK WASHER 3/8
619	PN03M	HEX NUT M8-1.25
620	P0679620	ADJUSTABLE BAR
621	PB42M	HEX BOLT M5-.8 X 20
622	P0679622	COVER
624	P6204	BALL BEARING 6204ZZ
625	PR25M	INT RETAINING RING 47MM
626	P0679626	SPROCKET
627	P0679627	LOCK HANDLE
628	PK06M	KEY 5 X 5 X 10
629	P0679629	CHAIN SPINDLE ADAPTER
630	PSB07	CAP SCREW 5/16-18 X 3/4
631	PS09	PHLP HD SCR 1/4-20 X 1/4
632	P0679632	GEAR BAR (LEFT)

REF	PART #	DESCRIPTION
633	P0679633	GEAR BAR (RIGHT)
634	PN14	HEX NUT #8-32
635	P0679635	CHAIN FIXING BOARD
636	PSB03	CAP SCREW 5/16-18 X 1
637	PB07	HEX BOLT 5/16-18 X 3/4
638	P0679638	FIXING BOARD
639	P0679639	CHAIN
640	PLN03	LOCK NUT 5/16-18
641	P0679641	CHAIN COVER
642	P0679642	COVER
643	P0679643	L-PLATE
644	PS07	PHLP HD SCR 1/4-20 X 3/8
645	PB09	HEX BOLT 5/16-18 X 1/2
646	PB09	HEX BOLT 5/16-18 X 1/2
647	P0679647	SUPPORT FOOT (LEFT)
648	P0679648	DUST COVER
649	P0679649	COPPER WEAR PIN
650	PN02	HEX NUT 5/16"-18
651	PB03	HEX BOLT 5/16-18 X 1
652	P0679524	CAP SCREW #8-32 X 1
653	PLN02M	LOCK NUT M5-.8
654	PN08	HEX NUT 3/8"-16
655	P0679655	TRACKING ADJUSTABLE BOARD
656	P0679656	BEARING SPACER
657	P0679657	CAP
658	P6002	BALL BEARING 6002ZZ
659	P0679659	TRACKING SPINDLE
660	P0679660	TRACKING SET
661	P0679661	SPINDLE FIXING BOARD

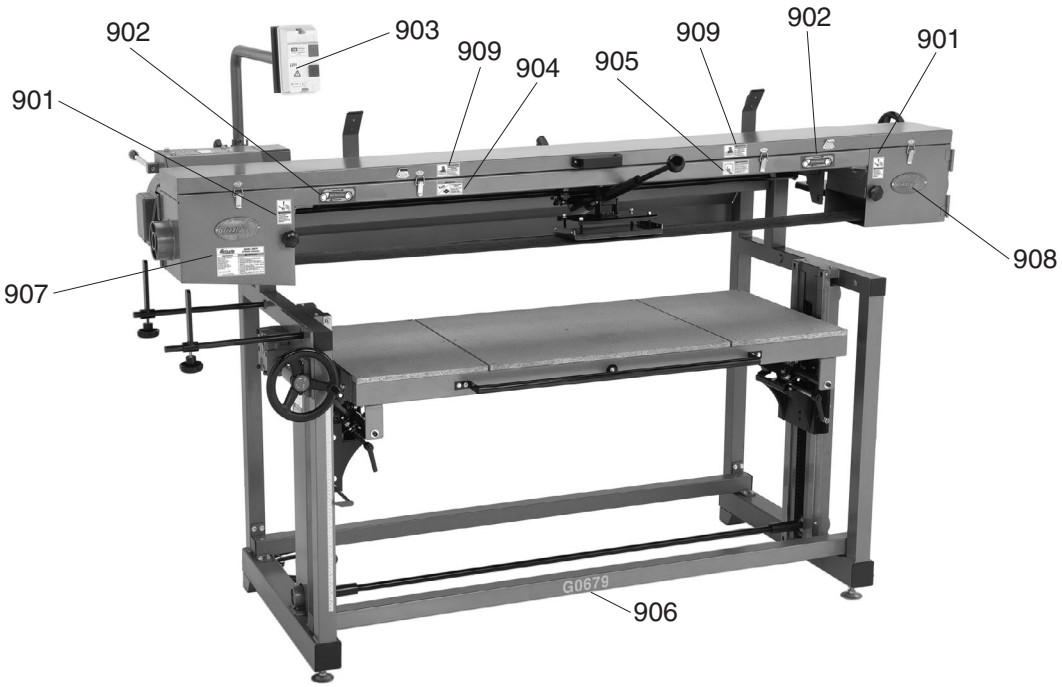
Platen Press Assembly Breakdown & Parts List

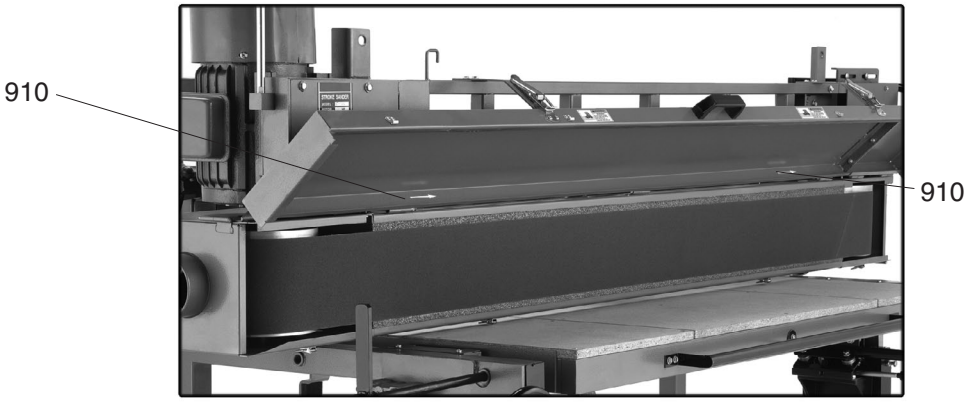


REF	PART #	DESCRIPTION
701	P0679701	PLATEN PRESS HANDLE
702	P0679702	BALL KNOB 1/2-12
703	P0679703	COMPRESSION SPRING
704	P0679704	PHLP HD SCR 3/16-18 X 3/8
705	P0679705	LOWER PRESS BRACKET
706	PFB03	FLANGE BOLT 1/4-20 X 1/2
707	P0679707	PLATEN FOAM PAD
708	P0679708	PLATEN GRAPHITE PAD
709	P0679709	FOAM TUBE
710	PSB03	CAP SCREW 5/16-18 X 1
711	P0679711	UPPER CLAMP PLATE
712	P0679712	LOWER CLAMP PLATE

REF	PART #	DESCRIPTION
713	P0679713	CLAMP BRACKET
714	P0679714	SPECIAL SCREW
715	PLN02	LOCK NUT 1/4-20
716	P0679716	UPPER PRESS BRACKET
801	PLN01	HEX NUT 3/8-16
802	P0679802	SPACER
803	P0679803	BEARING SHAFT
804	P6002	BALL BEARING 6002ZZ
805	P0679805	ECCENTRIC BEARING SHAFT
806	P0679806	TRACKING PLATE
807	P0679807	PRESS BRACKET
808	PW02	FLAT WASHER 3/8

Labels Breakdown & Parts List





REF	PART #	DESCRIPTION
901	PLABEL-63A	DISCONNECT POWER LABEL VS
902	P0679902	BELT DIRECTION LABEL
903	PLABEL-14A	ELECTRICITY LABEL 0.7"
904	PLABEL-57C	GLASSES RESPIRATOR LABEL HS
905	PLABEL-12D	READ MANUAL LABEL HS

REF	PART #	DESCRIPTION
906	P0679906	MODEL NUMBER LABEL
907	P0679907	MACHINE ID LABEL
908	G9987	GRIZZLY NAMEPLATE
909	P0679909	HAND INJURY WARNING LABEL
910	P0679910	DIRECTION ARROW LABEL

⚠WARNING

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine MUST maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, REPLACE that label before using the machine again. Contact Grizzly at (800) 523-4777 or www.grizzly.com to order new labels.

Grizzly Industrial, Inc. WARRANTY CARD

Name _____

Street _____

City _____ State _____ Zip _____

Phone # _____ Email _____ Invoice # _____

Model # _____ Order # _____ Serial # _____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. ***Of course, all information is strictly confidential.***

1. How did you learn about us?

____ Advertisement ____ Friend ____ Catalog
____ Card Deck ____ Website ____ Other:

2. Which of the following magazines do you subscribe to?

____ Cabinet Maker
____ Family Handyman
____ Hand Loader
____ Handy
____ Home Shop Machinist
____ Journal of Light Cont.
____ Live Steam
____ Model Airplane News
____ Modeltec
____ Old House Journal
____ Popular Mechanics
____ Popular Science
____ Popular Woodworking
____ Practical Homeowner
____ Precision Shooter
____ Projects in Metal
____ RC Modeler
____ Rifle
____ Shop Notes
____ Shotgun News
____ Today's Homeowner
____ Wood
____ Wooden Boat
____ Woodshop News
____ Woodsmith
____ Woodwork
____ Woodworker West
____ Woodworker's Journal
____ Other:

3. What is your annual household income?

____ $20,000-$29,000 ____ $30,000-$39,000 ____ $40,000-$49,000
____ $50,000-$59,000 ____ $60,000-$69,000 ____ $70,000+

4. What is your age group?

____ 20-29 ____ 30-39 ____ 40-49
____ 50-59 ____ 60-69 ____ 70+

5. How long have you been a woodworker/metalworker?

____ 0-2 Years ____ 2-8 Years ____ 8-20 Years ____ 20+ Years

6. How many of your machines or tools are Grizzly?

____ 0-2 ____ 3-5 ____ 6-9 ____ 10+

7. Do you think your machine represents a good value? _____ Yes _____ No

8. Would you recommend Grizzly Industrial to a friend? _____ Yes _____ No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?
Note: *We never use names more than 3 times.* _____ Yes _____ No

10. Comments: _____

_____

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WARRANTY AND RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number,'' which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

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